

(19) World Intellectual Property  
Organization  
International Bureau



(43) International Publication Date  
15 December 2005 (15.12.2005)

PCT

(10) International Publication Number  
**WO 2005/118519 A1**

(51) International Patent Classification<sup>7</sup>: **C07C 67/38**,  
69/67, 67/31, 69/675, 69/68, 51/09, 59/01, 59/08

(21) International Application Number:  
PCT/GB2005/001911

(22) International Filing Date: 18 May 2005 (18.05.2005)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
0411951.7 28 May 2004 (28.05.2004) GB

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(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

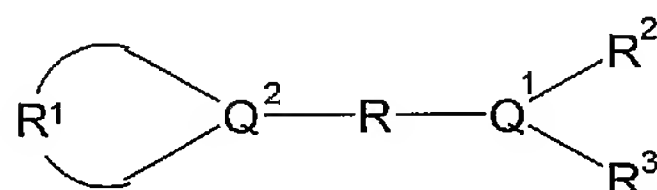
(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

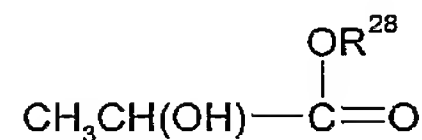
— with international search report

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(54) Title: ALKOXYCARBONYLATION OF VYNIL ESTERS



(I)



(III)

(57) Abstract: A process for the alkoxy carbonylation of a vinyl ester comprising reacting a vinyl ester with carbon monoxide in the presence of an alkanol and a catalyst system. The catalyst system used in the said process is obtainable by combining: a) a metal of Group VIII B or a compound thereof, and b) a bidentate ligand of general formula (I) wherein, R is a covalent bridging group; R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form an optionally substituted 2-Q<sup>2</sup>-tricyclo[3.3.1.1 {3,7}]decyl group or derivative thereof (2-PA); R<sup>2</sup> and R<sup>3</sup> independently represent univalent radicals upto 20 atoms or jointly form a bivalent radical of up to 20 atoms; and Q<sup>1</sup> and Q<sup>2</sup> each independently represent phosphorous, arsenic or antimony. The process is carried out for the production of a 3-hydroxy propanoate ester or acid of formula (II) CH<sub>2</sub>(OH)CH<sub>2</sub>C(O)OR<sup>28</sup>. The process may also be carried out for the production of a lactate ester or acid of formula (III).

WO 2005/118519 A1

## ALKOXYCARBONYLATION OF VINYL ESTERS

The present invention relates to the alkoxycarbonylation of an unsaturated ester, specifically vinyl acetate and, in particular but not exclusively, the use of the alkoxycarbonylation to  
5 provide a first step in the production of methyl lactate and 3-hydroxymethyl propanoate.

Currently methyl lactate is produced by esterification of lactic acid, which is produced either by synthetic methods or fermentation.

10 The main synthetic routes are based on the reactions of acetaldehyde. In one method, acetaldehyde is reacted with hydrogen cyanide to produce a lactonitrile, which is then hydrolysed. Alternatively, acetaldehyde can be reacted with carbon monoxide and water in the presence of a nickel (II) iodide or sulphuric acid catalyst. Synthetic routes produce racemic mixtures of lactic acid, and so racemic mixtures of methyl lactate result. In recent years,  
15 improvements in fermentation methods have made this a preferred route to lactic acid and its derivatives. Optically pure lactic acid can be produced by the fermentation of sugars with carefully chosen bacteria. Lactobacilli tend to be heat resistant, so fermentation at temperatures of around 50°C suppresses secondary reactions. The procedure is slow, and requires careful monitoring of pH, temperature and oxygen levels, but by selecting an appropriate bacteria  
20 culture, optically pure lactic acid, of both R and S forms can be produced.

Methyl lactate is used as a high boiling point solvent, and is present in a variety of materials such as detergents, degreasing agents, cosmetics and food flavourings. It is biodegradable, and so environmentally friendly.

25

A route to 1, 3-propanediol would be industrially favourable, as there is currently not a route to the diol that is commercially viable. In the 1980s, Davy Process Technology found a route to 1, 4-butanediol, by forming diethyl maleate from butanes over a solid acid catalyst, and then dehydrogenating it to the diol. 1, 4-butanediol is now widely used as a polymer component and  
30 also in fibre production and as a high boiling solvent. Polyhydric alcohols are often used in reactions with isocyanates to produce urethanes, and in reactions with acids and acid anhydrides to produce (poly) esters. 1, 3-propanediol is thought to have uses as a polymer component and as a high boiling point solvent.

35

The carbonylation of ethylenically unsaturated compounds using carbon monoxide in the presence of an alcohol or water and a catalyst system comprising a group VIB OR VIIB metal, example, palladium, and a phosphine ligand, example an alkyl phosphine, cycloalkyl phosphine, aryl phosphine, pyridyl phosphine or bidentate phosphine, has been described in numerous European patents and patent applications, example EP-A-0055875, EP-A-04489472, EP-A-0106379, EP-A-0235864, EP-A-0274795, EP-A-0499329, EP-A-0386833, EP-A-0441447, EP-A-0489472, EP-A-0282142, EP-A-0227160, EP-A-0495547 and EP-A-0495548. In particular, EP-A-0227160, EP-A-0495547 and EP-A-0495548 disclose that bidentate phosphine ligands provide catalyst systems which enable high reaction rates to be achieved.

10

WO96/19434 discloses that a particular group of bidentate phosphine compounds can provide remarkably stable catalysts which require little or no replenishment; that use of such bidentate catalysts leads to reaction rates which are significantly higher than those previously disclosed; that little or no impurities are produced at high conversions.

15

WO 01/68583 discloses rates for the same process used for higher alkenes when in the presence of an externally added aprotic solvent.

EP0495548B1 gives an example of vinyl acetate carbonylation employing the C3 bridged phosphine 1,3bis (di-tert-butylphosphino) propane. The rates quoted are 200 moles product per mole of Pd per hour and the result is the production of 1 and 2 – acetoxy methyl propanoate in a ratio of 40:60 (linear:branched).

WO 98/42717 discloses a modification to the bidentate phosphines used in EP0495548 wherein one or both phosphorous atoms are incorporated into an optionally substituted 2-phospha-tricyclo[3.3.1.1{3,7}]decyl group or a derivative thereof in which one or more of the carbon atoms are replaced by heteroatoms (“2-PA” group). The examples include a number of alkoxycarbonylations of ethene, propene and some higher terminal and internal olefins. In addition, hydroformylation of vinyl acetate giving a branched : linear product ratio of 10:1 is also disclosed. Notably, no alkoxycarbonylation of vinyl acetate is disclosed.

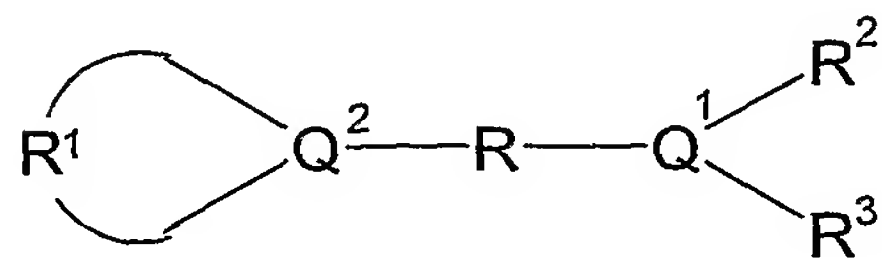
WO 03/070370 extends the teaching of WO 98/42717 to bidentate phosphines having 1, 2 substituted aryl bridges of the type disclosed in WO96/19434. The suitable olefin substrates disclosed include several types having various substituents. Notably, vinyl esters are not mentioned either generally or specifically.

Vinyl esters are known to hydrolyse easily into the corresponding acid or aldehyde . Accordingly, exposure of vinyl ester to acid should be avoided. Alkoxy carbonylation reactions with bidentate phosphines may proceed in the presence of Group VIB OR VIIB metals but such metals are utilised in the presence of a source of anions derived from acids having a pKa of less than 4. Accordingly, alkoxy carbonylation may be deemed unsuitable for carbonylation of vinyl ester.

According to a first aspect of the present invention there is provided a process for the alkoxy carbonylation of a vinyl ester comprising reacting a vinyl ester with carbon monoxide in the presence of an alkanol and of a catalyst system, the catalyst system obtainable by combining:

- (a) a metal of Group VIII B or a compound thereof; and
- (b) a bidentate ligand of general formula (I)

(I)



wherein:

R is a covalent bridging group;

R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form an optionally substituted 2-Q<sup>2</sup>-tricyclo[3.3.1.1{3,7}]decyl group or derivative thereof(2-PA);

R<sup>2</sup> and R<sup>3</sup> independently represent univalent radicals upto 20 atoms or jointly form a bivalent radical of up to 20 atoms;

Q<sup>1</sup> and Q<sup>2</sup> each independently represent phosphorous, arsenic or antimony.

Preferably, Q<sup>2</sup> is phosphorus and preferably, Q<sup>1</sup> is phosphorus.

Preferably,  $R^2$  represents  $CR^4(R^5)(R^6)$ , congressyl or adamantyl,  $R^3$  represents  $CR^7(R^8)(R^9)$ , congressyl or adamantyl, or  $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached form an optionally substituted 2- $Q^1$ -tricyclo[3.3.1.1{3,7}]decyl group or derivative thereof.

5

Preferably, the bidentate ligand is a bidentate phosphine, arsine or stibine ligand, preferably, a phosphine ligand.

The adamantyl group may optionally comprise, besides hydrogen atoms, one or more  
 10 substituents selected from lower alkyl,  $-OR^{19}$ ,  $-OC(O)R^{20}$ , halo, nitro,  $-C(O)R^{21}$ ,  $-C(O)OR^{22}$ , cyano, aryl,  $-N(R^{23})R^{24}$ ,  $-C(O)N(R^{25})R^{26}$ ,  $-C(S)(R^{27})R^{28}$ ,  $-CF_3$ ,  $-P(R^{56})R^{57}$ ,  $-PO(R^{58})(R^{59})$ ,  $-PO_3H_2$ ,  $-PO(OR^{60})(OR^{61})$ , or  $-SO_3R^{62}$ , wherein  $R^{19}$ ,  $R^{20}$ ,  $R^{21}$ ,  $R^{22}$ ,  $R^{23}$ ,  $R^{24}$ ,  $R^{25}$ ,  $R^{26}$ ,  $R^{27}$ ,  $R^{28}$ , lower alkyl, cyano and aryl are as defined herein and  $R^{56}$  to  $R^{62}$  each independently represent hydrogen, lower alkyl, aryl or Het.

15

Suitably, when the adamantyl group is substituted with one or more substituents as defined above, highly preferred substituents include unsubstituted  $C_1$  to  $C_8$  alkyl,  $-OR^{19}$ ,  $-OC(O)R^{20}$ , phenyl,  $-C(O)OR^{22}$ , fluoro,  $-SO_3H$ ,  $-N(R^{23})R^{24}$ ,  $-P(R^{56})R^{57}$ ,  $-C(O)N(R^{25})R^{26}$  and  $-PO(R^{58})(R^{59})$ ,  $-CF_3$ , wherein  $R^{19}$  represents hydrogen,  
 20 unsubstituted  $C_1$ - $C_8$  alkyl or phenyl,  $R^{20}$ ,  $R^{22}$ ,  $R^{23}$ ,  $R^{24}$ ,  $R^{25}$ ,  $R^{26}$  each independently represent hydrogen or unsubstituted  $C_1$ - $C_8$  alkyl,  $R^{56}$  to  $R^{59}$  each independently represent unsubstituted  $C_1$ - $C_8$  alkyl or phenyl.

Suitably, the adamantyl group may comprise, besides hydrogen atoms, up to 10 substituents as  
 25 defined above, preferably up to 5 substituents as defined above, more preferably up to 3 substituents as defined above. Suitably, when the adamantyl group comprises, besides hydrogen atoms, one or more substituents as defined herein, preferably each substituent is identical. Preferred substituents are unsubstituted  $C_1$ - $C_8$  alkyl and trifluoromethyl, particularly unsubstituted  $C_1$ - $C_8$  alkyl such as methyl. A highly preferred adamantyl group comprises  
 30 hydrogen atoms only i.e. the adamantyl group is not substituted.

Preferably, when more than one adamantyl group is present in a compound of formula I, each adamantyl group is identical.

35 The 2- $Q^2$ (or  $Q^1$ )-tricyclo[3.3.1.1{3,7}]decyl group (referred to hereinafter as a 2-meta-adamantyl group for convenience wherein 2-meta-adamantyl is a reference to 2-arsa-



adamantyl and/or 2-stiba-adamantyl and/or 2-phospha-adamantyl, preferably, 2-phospha-adamantyl) may optionally comprise, beside hydrogen atoms, one or more substituents. Suitable substituents include those substituents as defined herein in respect of the adamantyl group. Highly preferred substituents include lower alkyl, particularly unsubstituted C<sub>1</sub>-C<sub>8</sub> alkyl, especially methyl, trifluoromethyl, -OR<sup>19</sup> wherein R<sup>19</sup> is as defined herein particularly unsubstituted C<sub>1</sub>-C<sub>8</sub> alkyl or aryl, and 4-dodecylphenyl. When the 2-meta-adamantyl group includes more than one substituent, preferably each substituent is identical.

Preferably, the 2-meta-adamantyl group is substituted on one or more of the 1, 3, 5 or 7 positions with a substituent as defined herein. More preferably, the 2-meta-adamantyl group is substituted on each of the 1, 3 and 5 positions. Suitably, such an arrangement means the Q atom of the 2-meta-adamantyl group is bonded to carbon atoms in the adamantyl skeleton having no hydrogen atoms. Most preferably, the 2-meta-adamantyl group is substituted on each of the 1, 3, 5 and 7 positions. When the 2-meta-adamantyl group includes more than 1 substituent preferably each substituent is identical. Especially preferred substituents are unsubstituted C<sub>1</sub>-C<sub>8</sub> alkyl and trifluoromethyl, particularly unsubstituted C<sub>1</sub>-C<sub>8</sub> alkyl such as methyl.

Preferably, 2-meta-adamantyl represents unsubstituted 2-meta-adamantyl or 2-meta-adamantyl substituted with one or more unsubstituted C<sub>1</sub>-C<sub>8</sub> alkyl substituents, or a combination thereof.

Preferably, the 2-meta-adamantyl group includes additional heteroatoms, other than the 2-Q atom, in the 2-meta-adamantyl skeleton. Suitable additional heteroatoms include oxygen and sulphur atoms, especially oxygen atoms. More preferably, the 2-meta-adamantyl group includes one or more additional heteroatoms in the 6, 9 and 10 positions. Even more preferably, the 2-meta-adamantyl group includes an additional heteroatom in each of the 6, 9 and 10 positions. Most preferably, when the 2-meta-adamantyl group includes two or more additional heteroatoms in the 2-meta-adamantyl skeleton, each of the additional heteroatoms are identical. An especially preferred 2-meta-adamantyl group, which may optionally be substituted with one or more substituents as defined herein, includes an oxygen atom in each of the 6, 9 and 10 positions of the 2-meta-adamantyl skeleton.

Preferably, the 2-meta-adamantyl includes one or more oxygen atoms in the 2-meta-adamantyl skeleton.

Highly preferred 2-meta-adamantyl groups as defined herein include 2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxadamantyl group, 2-phospha-1,3,5-trimethyl-6,9,10-trioxadamantyl group, 2-phospha-1,3,5,7-tetra(trifluoromethyl)-6,9,10-trioxadamantyl group, and 2-phospha-1,3,5-tri(trifluoromethyl)-6,9,10-trioxadamantyl group. Most preferably, the 2-phospha-  
5 adamantyl is selected from 2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxadamantyl group or 2-phospha-1,3,5,-trimethyl-6,9,10-trioxadamantyl group.

Preferably, when more than one 2-meta-adamantyl group is present in a compound of formula I, each 2-meta-adamantyl group is identical.

10

The 2-meta-adamantyl group may be prepared by methods well known to those skilled in the art. Suitably, certain 2-phospha-adamantyl compounds are obtainable from Cytac Canada Inc of 901 Garner Road, Niagara Falls, Ontario, Canada L2E 6T4. Likewise corresponding 2-meta-adamantyl compounds of formula I etc may be obtained from the same supplier or  
15 prepared by analogous methods.

Suitable Group VIII B metals or a compound thereof which may be combined with a compound of formula I include cobalt, nickel, palladium, rhodium and platinum. Preferably, the Group VIII B metal is palladium or a compound thereof. Suitable compounds of such  
20 Group VIII B metals include salts of such metals with, or compounds comprising weakly coordinated anions derived from, nitric acid; sulphuric acid; lower alkanolic (up to C<sub>12</sub>) acids such as acetic acid and propionic acid; sulphonic acids such as methane sulphonic acid, chlorosulphonic acid, fluorosulphonic acid, trifluoromethane sulphonic acid, benzene sulphonic acid, naphthalene sulphonic acid, toluene sulphonic acid, e.g. p-toluene sulphonic  
25 acid, t-butyl sulphonic acid, and 2-hydroxypropane sulphonic acid; sulphonated ion exchange resins; perhalic acid such as perchloric acid; ; halogenated carboxylic acids such as trichloroacetic acid and trifluoroacetic acid; orthophosphoric acid; phosphonic acids such as benzenephosphonic acid; and acids derived from interactions between Lewis acids and Brønsted acids. Other sources which may provide suitable anions include the optionally  
30 halogenated tetraphenyl borate derivatives, e.g. perfluorotetraphenyl borate. Additionally, zero valent palladium complexes particularly those with labile ligands, e.g. triphenylphosphine or alkenes such as dibenzylideneacetone or styrene or tri(dibenzylideneacetone)dipalladium may be used.

35 The anion may be derived from or introduced as one or more of an acid having a pK<sub>a</sub> measured in aqueous solution at 18°C of less than 4, more preferably, less than 3, a salt with a

cation that does not interfere with the reaction, e.g. metal salts or largely organic salts such as alkyl ammonium, and a precursor, such as an ester, that can break down under reaction conditions to generate the anion in situ. Suitable acids and salts include the acids and salts, other than unsubstituted carboxylates, listed supra

5

- The quantity of anion present is not critical to the catalytic behaviour of the catalyst system. The molar ratio of anion to palladium may be from 1:1 to 500:1, preferably from 2:1 to 100:1 and particularly from 3:1 to 30:1. Where the anion is provided by an acid and salt the relative proportion of the acid and salt is not critical. However, where an anion is provided by acid or partially provided by acid the ratio of acid to group VIII B metal is preferably, at least 1:1 mol ( $H^+$ )/mol( $C^{2+}$ ) and preferably, less than at least 5:1 mol ( $H^+$ )/mol( $C^{2+}$ ), more preferably, the ratio is at least 2:1 and preferably, less than at least 3:1; most preferably, around a 2:1 ratio is preferred. By  $H^+$  is meant the amount of active acidic sites so that a mole of monobasic acid would have 1 mole of  $H^+$  whereas a mole of dibasic acid would have 2 moles of  $H^+$  and tribasic acids etc should be interpreted accordingly. Similarly, by  $C^{2+}$  is meant moles of metal having a  $2^+$  cationic charge so that for  $M^+$  ions the ratio of the metal cation should be adjusted accordingly. For example, an  $M^+$  cation should be taken as having 0.5 moles of  $C^{2+}$  per mole of  $M^+$ .
- 20 Preferably, the ratio of bidentate ligand to acid is at least 1:2 mol/mol( $H^+$ ) and preferably, the ratio of bidentate ligand to group VIII B metal is at least 1:1 mol/mol( $C^{2+}$ ). Preferably, the ligand is in excess of metal mol/mol( $C^{2+}$ ) and preferably in excess of a ratio of 1:2 mol/mol( $H^+$ ) with the acid. Excess ligand is advantageous as the ligand itself may act as a base to buffer the acid levels in the reaction and prevent degradation of vinyl ester. On the other hand the presence of acid activates the reaction mix and improves the overall rate of reaction.

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As mentioned, the catalyst system of the present invention may be used homogeneously or heterogeneously. Preferably, the catalyst system is used homogeneously.

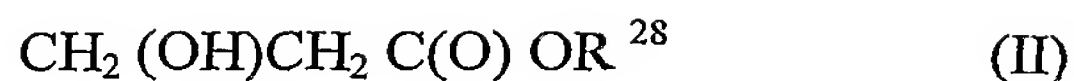
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Advantageously, use of the catalyst system of the present invention in the alkoxycarbonylation of vinyl esters gives predominantly linear product. This is surprising because hydroformylation of vinyl acetate using a 2-PA ligand with a propane bridge gave predominantly branched product in WO 98/42717.

35

Accordingly, in a second aspect of the present invention there is provided a process for the production of 3-hydroxy propanoate ester or acid of formula (II)





comprising the steps of :

5 alkoxy carbonylating vinyl ester with carbon monoxide in the presence of an alkanol and a catalyst system, the catalyst system obtainable by combining:

(a) a metal of Group VIII B or a compound thereof: and

10 (b) a bidentate ligand of general formula (I) in accordance with the first aspect as defined herein

wherein  $\text{R}^{28}$  is selected from H, or a  $\text{C}_1\text{-C}_{30}$  alkyl or aryl moiety which may be substituted or unsubstituted and either branched or linear and carrying out a treatment step on the said linear (n) product 1-acetoxy  $\text{CH}_2\text{CH}_2\text{C}(\text{O})\text{OR}^{28}$  to produce the 3-hydroxy propanoate ester or acid of  
15 formula (II).

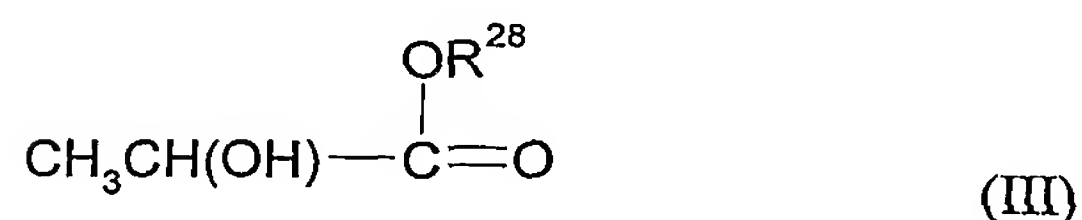
The linear (n) and branched (iso) products of the alkoxy carbonylation may be separated either before or after the treatment step. Preferably, the said products are separated from the reaction products by distillation.

20

According to a third aspect of the present invention there is provided the use of the catalyst system as defined in any of the 1<sup>st</sup> or 2<sup>nd</sup> aspects of the present invention for the production, preferably industrial product, of a 3-hydroxy propanoate ester of formula (II) the said production comprising the steps of alkoxy carbonylation of a vinyl ester followed by  
25 treatment of the linear (n) product of the alkoxy carbonylation.

Despite the foregoing, the invention does not exclude the possibility of utilising the branched product of the reaction.

30 Therefore, according to a fourth aspect of the present invention there is provided a process for the production of a lactate ester or acid of formula III



comprising the steps of alkoxycarbonylating vinyl ester with carbon monoxide in the presence of an alkanol and a catalyst system, the catalyst system obtainable by combining:

- (a) a metal of Group VIII B or a compound thereof; and
- 5 (b) a bidentate ligand, preferably phosphine ligand, of general formula (I) in accordance with the first aspect as defined herein

to produce a product comprising a branched (iso) product 2-acetoxy  $(CH_3)_2CH.C(O)OR$ ,<sup>28</sup> wherein  $R^{28}$  is selected from H, or a  $C_1$ - $C_{30}$  alkyl or aryl moiety which may be substituted or  
10 unsubstituted and either branched or linear and chemically treating the said branched (iso) product to produce the corresponding lactate or acid of formula III.

By treating or treatment herein is meant carrying out routine chemical treatment such as hydrolysis or transesterification reactions on the acetoxy product of the alkoxycarbonylation  
15 suitable to cleave the acetoxy group to produce the hydroxy acid or ester.

The linear (n) and branched (iso) products of the carbonylation may be separated either before or after the treatment step. Preferably, the products of the reaction are separated by distillation. The branched and linear products often have widely differing boiling points which  
20 makes distillation an effective separation technique for the products of the reaction.

Preferably, the ratio of linear:branched product from the alkoxycarbonylation process is greater than 1.5:1, more preferably, greater than 2:1, most preferably greater than 2.5:1.

25 According to a fifth aspect of the present invention there is provided the use of the catalyst system as defined in any of the 1<sup>st</sup> or 2<sup>nd</sup> aspects of the present invention for the production, preferably, industrial production, of a lactate ester or acid of formula (III)  
the said production comprising the steps of alkoxycarbonylation of a vinyl ester followed by treatment of the branched (iso) product of the alkoxycarbonylation to produce the ester or acid.

30

Advantageously, the lactate or 3-hydroxy propanoate esters or acids of the present invention may be hydrogenated to produce the 1,2 and 1,3 diols respectively.

Preferably, the treatment is hydrolysis or transesterification and is carried out by any suitable  
35 technique known to those skilled in the art. Such techniques are detailed in for example – “Kirkothmer Encyclopaedia of Chemical Technology”, volume 9, 4<sup>th</sup> edition page 783 –

“Hydrolysis of Organic Esters”. Such methods include base hydrolysis, acid hydrolysis, steam hydrolysis and enzymic hydrolysis. Preferably, the hydrolysis is base hydrolysis, more preferably, the hydrolysis is carried out in excess base and then acidified to produce the acid product. Hydrogenation of the hydrolysis product may be carried out by any suitable process  
 5 known to those skilled in the art. Preferably, vapour phase hydrogenation of the hydroxy alkanoate ester is carried out. A suitable technique has been exemplified in WO 01/70659 by Crabtree et al. Suitable experimental details are set out in examples 1-9 of the published application and illustrate the route to 1,3 propanediol from 3-hydroxy propanoic acid esters. Preferably, the hydrogenation is carried out in a hydrogenation zone containing a heterogenous  
 10 hydrogenation catalyst. Suitable conditions and catalysts are set out in WO 01/70659, the contents of which are incorporated herein by reference insofar as they relate to the hydrogenation of 3-hydroxy propanoic acid esters. However, for the purposes of the present application such hydrogenation reactions are also deemed applicable to hydrogenation of the lactate ester to produce 1,2 propane diol. Preferably, the transesterification is carried out with  
 15 the alkanol corresponding to the alkyl group of the alkyl ester product required for example methanol for converting acetoxy alkyl esters into hydroxy methyl esters and ethanol for converting acetoxy alkyl esters into hydroxy ethyl esters etc. Advantageously, this cleaves the acetoxy group but does not alter the hydroxy alkyl alkanoate. Preferably, the transesterification takes place in the presence of a suitable catalyst such as for example  
 20 methane sulphonic acid or p-toluene sulphonic acid.

The group R may represent an alkylene bridging group, preferably, a lower alkylene.

In one set of embodiments the bridging group R may be defined as -A-(K,D)Ar(E,Z)-B-  
 25 wherein:

Ar is a bridging group comprising an optionally substituted aryl moiety to which the Q<sup>1</sup> and Q<sup>2</sup> atoms, preferably, phosphorus atoms, are linked on available adjacent carbon atoms;

A and B each independently represent lower alkylene;

30

K, D, E and Z are substituents of the aryl moiety (Ar) and each independently represent hydrogen, lower alkyl, aryl, Het, halo, cyano, nitro, OR<sup>19</sup>, OC(O)R<sup>20</sup>, C(O)R<sup>21</sup>, C(O)OR<sup>22</sup>, NR<sup>23</sup>R<sup>24</sup>, C(O)NR<sup>25</sup>R<sup>26</sup>, C(S)R<sup>25</sup>R<sup>26</sup>, SR<sup>27</sup>, C(O)SR<sup>27</sup>, or -J-Q<sup>3</sup>(X<sup>5</sup>)X<sup>6</sup> where J represents lower alkylene; or two adjacent groups selected from K, Z, D and E together with the carbon atoms  
 35 of the aryl ring to which they are attached form a further phenyl ring, which is optionally substituted by one or more substituents selected from hydrogen, lower alkyl, halo, cyano, nitro,

OR<sup>19</sup>, OC(O)R<sup>20</sup>, C(O)R<sup>21</sup>, C(O)OR<sup>22</sup>, NR<sup>23</sup>R<sup>24</sup>, C(O)NR<sup>25</sup>R<sup>26</sup>, C(S)R<sup>25</sup>R<sup>26</sup>, SR<sup>27</sup> or C(O)SR<sup>27</sup> or, when Ar is a cyclopentadienyl group, Z may be represented by  $-M(L_1)_n(L_2)_m$  and Z is connected via a metal ligand bond to the cyclopentadienyl group;

- 5 X<sup>5</sup> represents CR<sup>13</sup>(R<sup>14</sup>)(R<sup>15</sup>), congressyl or adamantyl, X<sup>6</sup> represents CR<sup>16</sup>(R<sup>17</sup>)(R<sup>18</sup>), congressyl or adamantyl, or X<sup>5</sup> and X<sup>6</sup> together with Q<sup>3</sup> to which they are attached form an optionally substituted 2-Q<sup>3</sup>-tricyclo[3.3.1.1{3,7}]decyl group or derivative thereof;

Preferably Q<sup>3</sup> is a phospho.

10

Preferably in a compound of formula I when both K represents  $-A_3-Q^3(X^5)X^6$  and E represents  $-A_3-Q^3(X^5)X^6$ , then D represents  $-A_3-Q^3(X^5)X^6$ .

- 15 The 2-meta-adamantyl group may be a 2-Q<sup>2</sup>-tricyclo[3.3.1.1.{3,7}]decyl group formed by the combination of R<sup>1</sup> together with Q<sup>2</sup> to which it is attached, a 2-Q<sup>1</sup>- tricyclo [3.3.1.1.{3,7}] decyl group formed by the combination of R<sup>2</sup> and R<sup>3</sup> together with Q<sup>1</sup> to which they are attached, or a 2-Q<sup>3</sup> – tricyclo [3.3.1.1 {3,7}] decyl group formed by the combination of X<sup>5</sup> and X<sup>6</sup> together with Q<sup>3</sup> to which they are attached respectively, wherein Q<sup>1</sup>, Q<sup>2</sup> and Q<sup>3</sup> is in the 2-position of the adamantyl group of which it forms an integral part and each of Q<sup>1</sup>, Q<sup>2</sup> and Q<sup>3</sup> represents phosphorus, arsenic and/or antimony. Preferably, Q<sup>1</sup>, Q<sup>2</sup> and Q<sup>3</sup> represent phosphorous.
- 20

Preferred embodiments of the present invention include those wherein:

- 25 R<sup>2</sup> represents CR<sup>4</sup>(R<sup>5</sup>)(R<sup>6</sup>), R<sup>3</sup> represents CR<sup>7</sup>(R<sup>8</sup>)(R<sup>9</sup>), and R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form a 2-phospha-adamantyl group;

R<sup>2</sup> represents CR<sup>4</sup>(R<sup>5</sup>)(R<sup>6</sup>), R<sup>3</sup> represents adamantyl, R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form a 2-phospha-adamantyl group;

30

R<sup>2</sup> represents CR<sup>4</sup>(R<sup>5</sup>)(R<sup>6</sup>), R<sup>3</sup> represents congressyl, R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form a 2-phospha-adamantyl group;

- R<sup>2</sup> and R<sup>3</sup> independently represent adamantyl, and R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form a 2-phospha-adamantyl group;
- 35



$R^2$  and  $R^3$  independently represent congressyl, and  $R^1$  together with  $Q^2$  to which it is attached form a 2-phospha-adamantyl group;

$R^1$  together with  $Q^2$  to which it is attached form a 2-phospha-adamantyl group, and  $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached form a 2-phospha-adamantyl group;

Highly preferred embodiments of the present invention include those wherein:

$R^1$  together with  $Q^2$  to which it is attached form a 2-phospha-adamantyl group, and  $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached form a 2-phospha-adamantyl group;

Preferably in a compound of formula I,  $R^2$  is identical to  $R^3$ .

Preferably, in the compound of formula I,  $R^2$  and  $R^3$  represent identical substituents, and  $X^5$  and  $X^6$  (when present) represent identical substituents, more preferably,  $R^2$  and  $R^3$  and  $X^5$  and  $X^6$  (when present) combine to be identical with  $R^1$ .

Particularly preferred combinations in the present invention include those wherein:-

- (1)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;  
 $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-phospha-adamantyl;  
A and B are the same and represent  $-\text{CH}_2-$ ;  
K, D and E are the same and represent hydrogen or unsubstituted  $\text{C}_1\text{-C}_6$  alkyl, particularly hydrogen;  
 $Q^1$  and  $Q^2$  both represent phosphorus.
- (2)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;  
 $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-meta-adamantyl;  
K represents  $-\text{CH}_2\text{-Q}^3(\text{X}^5)\text{X}^6$  wherein  $\text{X}^5$  and  $\text{X}^6$  together with  $\text{Q}^3$  to which they are attached represents 2-meta-adamantyl;  
A and B are the same and represent  $-\text{CH}_2-$ ;  
 $Q^1$ ,  $Q^2$  and  $Q^3$  each represent phosphorus;  
D and E are the same and represent hydrogen or unsubstituted  $\text{C}_1\text{-C}_6$  alkyl, particularly hydrogen.

- (3)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;  
 $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-meta-adamantyl;  
 K represents  $-\text{CH}_2-\text{Q}^3(\text{X}^5)\text{X}^6$  wherein  $\text{X}^5$  and  $\text{X}^6$  together with  $Q^3$  to which they are  
 5 attached represents 2-meta-adamantyl;  
 A and B are the same and represent  $-\text{CH}_2-$ ;  
 $Q^1$ ,  $Q^2$  and  $Q^3$  each represent phosphorus.
- 10 (4)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;  
 $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-meta-adamantyl;  
 A and B are the same and represent  $-\text{CH}_2-$ ;  
 $Q^1$  and  $Q^2$  both represent phosphorus;  
 K represents hydrogen or unsubstituted  $\text{C}_1\text{-C}_6$  alkyl, particularly hydrogen;  
 15 D and E together with the carbon atoms of the cyclopentadienyl ring to which they  
 are attached form an unsubstituted phenyl ring;  
 M represents Fe;  
 $n = 1$  and  $L_1$  represents cyclopentadienyl, particularly unsubstituted  
 cyclopentadienyl, and  $m = 0$ .
- 20 (5)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;  
 $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-meta-adamantyl;  
 A and B are the same and represent  $-\text{CH}_2-$ ;  
 K, D and E are the same and represent hydrogen or unsubstituted  $\text{C}_1\text{-C}_6$  alkyl,  
 25 particularly hydrogen;  
 $Q^1$  and  $Q^2$  both represent phosphorus;  
 M represents Fe;  
 $n = 1$  and  $L_1$  represents cyclopentadienyl, particularly unsubstituted  
 cyclopentadienyl, and  $m = 0$ .
- 30 (6)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;  
 $R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-meta-adamantyl;  
 K represents  $-\text{CH}_2-\text{Q}^3(\text{X}^5)\text{X}^6$  wherein  $\text{X}^5$  and  $\text{X}^6$  together with  $Q^3$  to which they are  
 35 attached represents 2-meta-adamantyl;  
 A and B are the same and represent  $-\text{CH}_2-$ ;

$Q^1$ ,  $Q^2$  and  $Q^3$  each represent phosphorus;

D and E are the same and represent hydrogen or unsubstituted  $C_1$ - $C_6$  alkyl, particularly hydrogen;

M represents Fe;

5  $n = 1$  and  $L_1$  represents cyclopentadienyl, particularly unsubstituted cyclopentadienyl, and  $m = 0$ .

(7)  $R^1$  together with  $Q^2$  to which it is attached represents 2-meta-adamantyl;

$R^2$  and  $R^3$  together with  $Q^1$  to which they are attached represents 2-meta-adamantyl;

10 K represents  $-CH_2-Q^3(X^5)X^6$  wherein  $X^5$  and  $X^6$  together with  $Q^3$  to which they are attached represents 2-meta-adamantyl;

A and B are the same and represent  $-CH_2-$ ;

$Q^1$ ,  $Q^2$  and  $Q^3$  each represent phosphorus;

15 D and E together with the carbon atoms of the cyclopentadienyl ring to which they are attached form an unsubstituted phenyl ring;

M represents Fe;

$n = 1$  and  $L_1$  represents cyclopentadienyl, particularly unsubstituted cyclopentadienyl, and  $m = 0$ .

20

$R^4$  to  $R^9$  and  $R^{13}$  to  $R^{18}$  each independently represent lower alkyl, aryl, or Het;

$R^{19}$  to  $R^{27}$  each independently represent hydrogen, lower alkyl, aryl or Het;

M represents a Group VIB or VIIIB metal or metal cation thereof;

25

$L_1$  represents a cyclopentadienyl, indenyl or aryl group each of which groups are optionally substituted by one or more substituents selected from hydrogen, lower alkyl, halo, cyano, nitro,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  $C(S)R^{25}R^{26}$ ,  $SR^{27}$ ,  $C(O)SR^{27}$  or ferrocenyl;

30

$L_2$  represents one or more ligands each of which are independently selected from hydrogen, lower alkyl, alkylaryl, halo, CO,  $PR^{43}R^{44}R^{45}$  or  $NR^{46}R^{47}R^{48}$ ;

$R^{43}$  to  $R^{48}$  each independently represent hydrogen, lower alkyl, aryl or Het;

35

$n = 0$  or  $1$ ;

and  $m = 0$  to  $5$ ;

provided that when  $n = 1$  then  $m$  equals  $0$ , and when  $n$  equals  $0$  then  $m$  does not equal  $0$ ;

5

$Q^3$  (when present) represents phosphorous, arsenic or antimony.

Preferably, the Group VIII B metal is palladium.

10 Preferably, when K, D, E or Z represent  $-J-Q^3(CR^{13}(R^{14})(R^{15}))CR^{16}(R^{17})(R^{18})$ , the respective K, D, E or Z is on the aryl carbon adjacent the aryl carbon to which A or B is connected or, if not so adjacent, is adjacent a remaining K, D, E or Z group which itself represents  $-J-Q^3(CR^{13}(R^{14})(R^{15}))CR^{16}(R^{17})(R^{18})$ .

15 For ease of reference, any one or more of the five aspects of the invention may be referred to herein as the process of the invention.

Suitably, the process of the invention may be used to catalyse the carbonylation of a vinyl ester in the presence of carbon monoxide and a hydroxyl group containing compound i.e. the  
20 process of the invention may catalyse the conversion of a vinyl ester to the corresponding acetoxy carboxylic ester. Conveniently, the process of the invention may utilise highly stable compounds under typical carbonylation reaction conditions such that they require little or no replenishment. Conveniently, the process of the invention may have a high rate for the carbonylation reaction of a vinyl ester. Conveniently, the process of the invention may  
25 promote high conversion rates of the vinyl ester, thereby yielding the desired product in high yield with little or no impurities. Consequently, the commercial viability of a carbonylation process, such as the carbonylation of a vinyl ester, may be increased by employing the process of the invention.

30 The term "Ar" or "aryl" when used herein, includes five-to-ten-membered, preferably six to ten membered, carbocyclic aromatic or pseudo aromatic groups, such as phenyl, ferrocenyl and naphthyl, which groups are optionally substituted with, in addition to K, D, E or Z, one or more substituents selected from aryl, lower alkyl (which alkyl group may itself be optionally substituted or terminated as defined below), Het, halo, cyano, nitro,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  
35  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  $SR^{27}$ ,  $C(O)SR^{27}$  or  $C(S)NR^{25}R^{26}$  wherein  $R^{19}$  to  $R^{27}$  each



independently represent hydrogen, aryl or lower alkyl (which alkyl group may itself be optionally substituted or terminated as defined below).

Suitably, when Ar or aryl is cyclopentadienyl and when D and E together with the carbon atoms of the cyclopentadienyl ring to which they are attached form a phenyl ring, the metal M or cation thereof is attached to an indenyl ring system. In a preferred embodiment Ar represents phenyl or naphthyl, more preferably, phenyl and in either case they may be optionally substituted as set out in the previous paragraph.

By the term "M represents a Group VIB or VIIB metal" in a compound of formula I we include metals such as Cr, Mo, W, Fe, Co, Ni, Ru, Rh, Os, Ir, Pt and Pd. Preferably, the metals are selected from Cr, Mo, W, Fe, Co, Ni, Ru and Rh. For the avoidance of doubt, references to Group VIB or VIIB metals herein should be taken to include Groups 6, 8, 9 and 10 in the modern periodic table nomenclature.

15

By the term "metal cation thereof" we mean that the Group VIB or VIIB metal (M) in the compound of formula I as defined herein has a positive charge. Suitably, the metal cation may be in the form of a salt or may comprise weakly coordinated anions derived from halo, nitric acid; sulphuric acid; lower alkanolic (up to C<sub>12</sub>) acids such as acetic acid and propionic acid; sulphonic acids such as methane sulphonic acid, chlorosulphonic acid, fluorosulphonic acid, trifluoromethane sulphonic acid, benzene sulphonic acid, naphthalene sulphonic acid, toluene sulphonic acid, e.g. p-toluene sulphonic acid, t-butyl sulphonic acid, and 2-hydroxypropane sulphonic acid; sulphonated ion exchange resins; perhalic acid such as perchloric acid; perfluorinated carboxylic acid such as trichloroacetic acid and trifluoroacetic acid; orthophosphoric acid; phosphonic acid such as benzene phosphonic acid; and acids derived from interactions between Lewis acids and Brønsted acids. Other sources which may provide suitable anions include the tetraphenyl borate derivatives.

Preferably M represents a Group VIB or VIIB metal. In other words the total electron count for the metal M is 18.

Halo groups, which L<sub>2</sub> may represent and with which the above-mentioned groups may be substituted or terminated, include fluoro, chloro, bromo and iodo.

Suitably, if A represents cyclopentadienyl and n = 1, the compounds of formula I may contain either two cyclopentadienyl rings, two indenyl rings or one indenyl and one cyclopentadienyl

ring (each of which ring systems may optionally be substituted as described herein). Such compounds may be referred to as “sandwich compounds” as the metal M or metal cation thereof is sandwiched by the two ring systems. The respective cyclopentadienyl and/or indenyl ring systems may be substantially coplanar with respect to each other or they may be tilted  
5 with respect to each other (commonly referred to as bent metallocenes).

Alternatively, when  $n = 1$ , the compounds of the invention may contain either one cyclopentadienyl or one indenyl ring (each of which ring systems may optionally be substituted as described herein) and one aryl ring (i.e.  $L_1$  represents aryl) which is optionally  
10 substituted as defined herein. Suitably, when  $n = 1$  and  $L_1$  represents aryl then the metal M of the compounds of formula I as defined herein is typically in the form of the metal cation.

Suitably, when  $n = 0$ , the compounds of the invention contain only one cyclopentadienyl or indenyl ring (each of which ring systems may optionally be substituted as described herein).  
15 Such compounds may be referred to as “half sandwich compounds”. Preferably, when  $n = 0$  then  $m$  represents 1 to 5 so that the metal M of the compounds of formula I has an 18 electron count. In other words, when metal M of the compounds of formula I is iron, the total number of electrons contributed by the ligands  $L_2$  is typically five.

20 Suitably, the metal M or metal cation thereof in the cyclopentadienyl compounds of formula I is typically bonded to the cyclopentadienyl ring(s) or the cyclopentadienyl moiety of the indenyl ring(s). Typically, the cyclopentadienyl ring or the cyclopentadienyl moiety of the indenyl ring exhibits a pentahapto bonding mode with the metal; however other bonding modes between the cyclopentadienyl ring or cyclopentadienyl moiety of the indenyl ring and  
25 the metal, such as trihapto coordination, are also embraced by the scope of the present invention.

Preferably, in the compound of formula I wherein Ar is cyclopentadienyl, M represents Cr, Mo, Fe, Co or Ru, or a metal cation thereof. Even more preferably, M represents Cr, Fe, Co or  
30 Ru or a metal cation thereof. Most preferably, M is selected from a Group VIIIB metal or metal cation thereof. An especially preferred Group VIIIB metal (M) is Fe. Although the metal M as defined herein may be in a cationic form, preferably it carries essentially no residual charge due to coordination with  $L_1$  and/or  $L_2$  as defined herein.

35 Preferably, when  $n = 1$  in the compound of formula I,  $L_1$  represents cyclopentadienyl, indenyl or aryl each of which rings are optionally substituted by one or more substituents selected from

hydrogen, lower alkyl, halo, cyano,  $\text{OR}^{19}$ ,  $\text{OC(O)R}^{20}$ ,  $\text{C(O)R}^{21}$ ,  $\text{C(O)OR}^{22}$ ,  $\text{NR}^{23}\text{R}^{24}$ ,  $\text{SR}^{27}$  or ferrocenyl (by which is meant the cyclopentadienyl, indenyl or aryl ring which  $\text{L}_1$  may represent is bonded directly to the cyclopentadienyl ring of the metallocenyl group). More preferably, if the cyclopentadienyl, indenyl or aryl ring which  $\text{L}_1$  may represent is substituted it is preferably substituted with one or more substituents selected from  $\text{C}_1\text{-C}_6$  alkyl, halo, cyano,  $\text{OR}^{19}$ ,  $\text{OC(O)R}^{20}$ ,  $\text{C(O)R}^{21}$ ,  $\text{C(O)OR}^{22}$ ,  $\text{NR}^{23}\text{R}^{24}$  where  $\text{R}^{19}$ ,  $\text{R}^{20}$ ,  $\text{R}^{21}$ ,  $\text{R}^{22}$ ,  $\text{R}^{23}$  and  $\text{R}^{24}$  each independently represent hydrogen or  $\text{C}_1\text{-C}_6$  alkyl.

Preferably, when  $n = 1$ ,  $\text{L}_1$  represents cyclopentadienyl, indenyl, phenyl or naphthyl optionally substituted as defined herein. Preferably, the cyclopentadienyl, indenyl, phenyl or naphthyl groups are unsubstituted. More preferably,  $\text{L}_1$  represents cyclopentadienyl, indenyl or phenyl, each of which rings are unsubstituted. Most preferably,  $\text{L}_1$  represents unsubstituted cyclopentadienyl.

In a particularly preferred embodiment of the present invention, in a compound of formula I,  $n = 1$ ,  $\text{L}_1$  is as defined herein and  $m = 0$ .

Alternatively, when  $n$  is equal to zero and  $m$  is not equal to zero in a compound of formula I,  $\text{L}_2$  represents one or more ligands each of which are independently selected from lower alkyl, halo, CO,  $\text{PR}^{43}\text{R}^{44}\text{R}^{45}$  or  $\text{NR}^{46}\text{R}^{47}\text{R}^{48}$ . More preferably,  $\text{L}_2$  represents one or more ligands each of which are independently selected from  $\text{C}_1$  to  $\text{C}_4$  alkyl, halo, particularly chloro, CO,  $\text{PR}^{43}\text{R}^{44}\text{R}^{45}$  or  $\text{NR}^{46}\text{R}^{47}\text{R}^{48}$ , wherein  $\text{R}^{43}$  to  $\text{R}^{48}$  are independently selected from hydrogen,  $\text{C}_1$  to  $\text{C}_6$  alkyl or aryl, such as phenyl.

In a particularly preferred alternative embodiment of the present invention, in a compound of formula I,  $n = 0$ ,  $\text{L}_2$  is as defined herein and  $m = 3$  or  $4$ , particularly  $3$ .

$\text{M}$  represents a metal selected from Cr, Mo, Fe, Co or Ru or a metal cation thereof;

$\text{L}_1$  represents cyclopentadienyl, indenyl, naphthyl or phenyl, each of which rings may be optionally substituted by one or more substituents selected from  $\text{C}_1\text{-C}_6$  alkyl, halo, cyano,  $\text{OR}^{19}$ ,  $\text{OC(O)R}^{20}$ ,  $\text{C(O)R}^{21}$ ,  $\text{C(O)OR}^{22}$ ,  $\text{NR}^{23}\text{R}^{24}$ ;

$\text{L}_2$  represents one or more ligands each of which ligands are independently selected from  $\text{C}_1\text{-C}_6$  alkyl, halo, CO,  $\text{PR}^{43}\text{R}^{44}\text{R}^{45}$  or  $\text{NR}^{46}\text{R}^{47}\text{R}^{48}$ ;

$n = 0$  or  $1$ ;

and  $m = 0$  to  $4$ ;

provided that when  $n = 1$  then  $m = 0$  and when  $m$  does not equal zero then  $n = 0$ .

5 Further preferred compounds of formula I include those wherein:

M represents iron or a cation thereof;

10  $L_1$  represents cyclopentadienyl, indenyl or phenyl group, each of which groups are optionally substituted by one or more substituents selected from  $C_1$ - $C_6$  alkyl, halo, cyano,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)R^{22}$ ;

15  $L_2$  represents one or more ligands each of which are independently selected from  $C_1$ - $C_6$  alkyl, halo, CO,  $PR^{43}R^{44}R^{45}$  or  $NR^{46}R^{47}R^{48}$ , where  $R^{43}$  to  $R^{48}$  are independently selected from hydrogen,  $C_1$ - $C_6$  alkyl or phenyl;

$n = 0$  or  $1$ ; and  $m = 0$  to  $4$ .

Still further preferred compounds of formula I include those wherein:

20

$L_1$  represents unsubstituted cyclopentadienyl, indenyl or phenyl, particularly unsubstituted cyclopentadienyl; and,  $n = 1$  and  $m = 0$ .

Alternative preferred compounds of formula I include those wherein:

25

$n = 0$ ;

30  $L_2$  represents one or more ligands each of which are independently selected from  $C_1$  to  $C_6$  alkyl, halo, CO,  $PR^{43}R^{44}R^{45}$  or  $NR^{46}R^{47}R^{48}$ , where  $R^{43}$  to  $R^{48}$  are independently selected from hydrogen,  $C_1$ - $C_6$  alkyl or phenyl; and  $m = 1$  to  $4$ , particularly  $3$  or  $4$ . For example, when  $m=3$  the three ligands which  $L_2$  may represent include  $(CO)_2$ halo,  $(PR^{43}R^{44}R^{45})_2$ halo or  $(NR^{46}R^{47}R^{48})_2$ halo.

35 References to vinyl ester herein include references to substituted or unsubstituted vinyl acetate of formula (IV):





wherein  $R^{29}$  may be selected from hydrogen, lower alkyl, aryl, Het, halo, cyano, nitro,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  $C(S)R^{25}R^{26}$ ,  $SR^{27}$ ,  $C(O)SR^{29}$  wherein  
 5  $R^{19}$ - $R^{27}$  are as defined herein.

Preferably,  $R^{29}$  is selected from hydrogen, lower alkyl, phenyl or lower alkylphenyl. More preferably, hydrogen, phenyl,  $C_1$ - $C_6$  alkylphenyl or  $C_1$ - $C_6$  alkyl, such as methyl, ethyl, propyl, butyl, pentyl and hexyl, even more preferably,  $C_1$ - $C_6$  alkyl, especially methyl.

10

Preferably,  $R^{30}$ - $R^{32}$  each independently represent hydrogen, lower alkyl, aryl or Het as defined herein. Most preferably,  $R^{30}$ - $R^{32}$  represent hydrogen. As mentioned above,  $R^{28}$  may be optionally substituted, preferably, with one or more substituents selected from lower alkyl, aryl, Het, halo, cyano, nitro,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  
 15  $C(S)R^{25}R^{26}$ ,  $SR^{27}$  or  $C(O)SR^{27}$  as defined herein.

$R^{28}$  is most preferably the alkyl/aryl group derived from a  $C_1$ - $C_8$  alkanol such as methanol, ethanol, propanol, iso-propanol, iso-butanol, t-butyl alcohol, n-butanol, phenol and chlorocapryl alcohol. The most preferred groups are methyl and ethyl, the most especially  
 20 preferred group is methyl.

The term "Het", when used herein, includes four-to-twelve-membered, preferably four-to-ten-membered ring systems, which rings contain one or more heteroatoms selected from nitrogen, oxygen, sulphur and mixtures thereof, and which rings may contain one or more double bonds  
 25 or be non-aromatic, partly aromatic or wholly aromatic in character. The ring systems may be monocyclic, bicyclic or fused. Each "Het" group identified herein is optionally substituted by one or more substituents selected from halo, cyano, nitro, oxo, lower alkyl (which alkyl group may itself be optionally substituted or terminated as defined below)  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  $SR^{27}$ ,  $C(O)SR^{27}$  or  $C(S)NR^{25}R^{26}$  wherein  $R^{19}$  to  $R^{27}$  each  
 30 independently represent hydrogen, aryl or lower alkyl (which alkyl group itself may be optionally substituted or terminated as defined below). The term "Het" thus includes groups such as optionally substituted azetidiny, pyrrolidiny, imidazolyl, indolyl, furanyl, oxazolyl, isoxazolyl, oxadiazolyl, thiazolyl, thiadiazolyl, triazolyl, oxatriazolyl, thiatriazolyl, pyridazinyl, morpholinyl, pyrimidinyl, pyrazinyl, quinolinyl, isoquinolinyl, piperidinyl,  
 35 pyrazolyl and piperazinyl. Substitution at Het may be at a carbon atom of the Het ring or, where appropriate, at one or more of the heteroatoms.

“Het” groups may also be in the form of an N oxide.

The term “lower alkyl” when used herein, means C<sub>1</sub> to C<sub>10</sub> alkyl and includes methyl, ethyl,  
5 propyl, butyl, pentyl, hexyl and heptyl groups. Unless otherwise specified, alkyl groups may,  
when there is a sufficient number of carbon atoms, be linear or branched, be saturated or  
unsaturated, be cyclic, acyclic or part cyclic/acyclic, and/or be substituted or terminated by one  
or more substituents selected from halo, cyano, nitro, OR<sup>19</sup>, OC(O)R<sup>20</sup>, C(O)R<sup>21</sup>, C(O)OR<sup>22</sup>,  
NR<sup>23</sup>R<sup>24</sup>, C(O)NR<sup>25</sup>R<sup>26</sup>, SR<sup>27</sup>, C(O)SR<sup>27</sup>, C(S)NR<sup>25</sup>R<sup>26</sup>, aryl or Het, wherein R<sup>19</sup> to R<sup>27</sup> each  
10 independently represent hydrogen, aryl or lower alkyl, and/or be interrupted by one or more  
oxygen or sulphur atoms, or by silano or dialkylsilicon groups.

Lower alkyl groups or alkyl groups which R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>5</sup>, R<sup>6</sup>, R<sup>7</sup>, R<sup>8</sup>, R<sup>9</sup>, R<sup>10</sup>, R<sup>11</sup>, R<sup>12</sup>, R<sup>13</sup>,  
R<sup>14</sup>, R<sup>15</sup>, R<sup>16</sup>, R<sup>17</sup>, R<sup>18</sup>, R<sup>19</sup>, R<sup>20</sup>, R<sup>21</sup>, R<sup>22</sup>, R<sup>23</sup>, R<sup>24</sup>, R<sup>25</sup>, R<sup>26</sup>, R<sup>27</sup>, R<sup>28</sup>, R<sup>29</sup>, R<sup>30</sup>, R<sup>31</sup>, R<sup>32</sup>, K, D, E  
15 and Z may represent and with which aryl and Het may be substituted, may, when there is a  
sufficient number of carbon atoms, be linear or branched, be saturated or unsaturated, be  
cyclic, acyclic or part cyclic/acyclic, and/or be interrupted by one or more of oxygen or  
sulphur atoms, or by silano or dialkylsilicon groups, and/or be substituted by one or more  
substituents selected from halo, cyano, nitro, OR<sup>19</sup>, OC(O)R<sup>20</sup>, C(O)R<sup>21</sup>, C(O)OR<sup>22</sup>, NR<sup>23</sup>R<sup>24</sup>,  
20 C(O)NR<sup>25</sup>R<sup>26</sup>, SR<sup>27</sup>, C(O)SR<sup>27</sup>, C(S)NR<sup>25</sup>R<sup>26</sup>, aryl or Het wherein R<sup>19</sup> to R<sup>27</sup> each  
independently represent hydrogen, aryl or lower alkyl.

Similarly, the term “lower alkylene” which R, A, B and J (when present) represent in a  
compound of formula I, when used herein, includes C<sub>1</sub> to C<sub>10</sub> groups which can be bonded at  
25 two places on the group and is otherwise defined in the same way as “lower alkyl”.

Halo groups with which the above-mentioned groups may be substituted or terminated include  
fluoro, chloro, bromo and iodo.

30 Where a compound of a formula herein (eg. formulas I-IV) contains an alkenyl group, cis (E)  
and trans (Z) isomerism may also occur. The present invention includes the individual  
stereoisomers of the compounds of any of the formulas defined herein and, where appropriate,  
the individual tautomeric forms thereof, together with mixtures thereof. Separation of  
diastereoisomers or cis and trans isomers may be achieved by conventional techniques, e.g. by  
35 fractional crystallisation, chromatography or H.P.L.C. of a stereoisomeric mixture of a  
compound one of the formulas or a suitable salt or derivative thereof. An individual

enantiomer of a compound of one of the formulas may also be prepared from a corresponding optically pure intermediate or by resolution, such as by H.P.L.C. of the corresponding racemate using a suitable chiral support or by fractional crystallisation of the diastereoisomeric salts formed by reaction of the corresponding racemate with a suitable optically active acid or  
5 base, as appropriate.

All stereoisomers are included within the scope of the process of the invention.

It will be appreciated by those skilled in the art that the compounds of formula I (b) may  
10 function as ligands that coordinate with the Group VIIIB metal or compound thereof (a) to form the compounds for use in the invention. Typically, the Group VIIIB metal or compound thereof (a) coordinates to the one or more phosphorous, arsenic and/or antimony atoms of the compound of formula I.

15 Preferably,  $R^4$  to  $R^9$ ,  $R^{13}$  to  $R^{18}$  and  $R^{28}$  each independently represent lower alkyl or aryl. More preferably,  $R^4$  to  $R^9$ ,  $R^{13}$  to  $R^{18}$  and  $R^{28}$  each independently represent  $C_1$  to  $C_6$  alkyl,  $C_1$ - $C_6$  alkyl phenyl (wherein the phenyl group is optionally substituted as defined herein) or phenyl (wherein the phenyl group is optionally substituted as defined herein). Even more preferably,  $R^4$  to  $R^9$ ,  $R^{13}$  to  $R^{18}$  or  $R^{28}$  each independently represent  $C_1$  to  $C_6$  alkyl, which is optionally  
20 substituted as defined herein. Most preferably,  $R^4$  to  $R^9$ ,  $R^{13}$  to  $R^{18}$  or  $R^{28}$  each represent non-substituted  $C_1$  to  $C_6$  alkyl such as methyl, ethyl, n-propyl, iso-propyl, n-butyl, iso-butyl, tert-butyl, pentyl, hexyl and cyclohexyl.

Alternatively, or additionally, each of the groups  $R^4$  to  $R^6$ ,  $R^7$  to  $R^9$ ,  $R^{13}$  to  $R^{15}$  or  $R^{16}$  to  $R^{18}$   
25 together independently may form cyclic structures such as l-norbornyl or l-norbornadienyl. Further examples of composite groups include cyclic structures formed between  $R^4$  -  $R^9$  and  $R^{13}$  -  $R^{18}$ . Alternatively, one or more of the groups may represent a solid phase to which the ligand is attached.

30 In a particularly preferred embodiment of the present invention  $R^4$ ,  $R^7$ ,  $R^{13}$  and  $R^{16}$  each represent the same lower alkyl, aryl or Het moiety as defined herein,  $R^5$ ,  $R^8$ ,  $R^{14}$  and  $R^{17}$  each represent the same lower alkyl, aryl or Het moiety as defined herein, and  $R^6$ ,  $R^9$ ,  $R^{15}$  and  $R^{18}$  each represent the same lower alkyl, aryl or Het moiety as defined herein. More preferably  $R^4$ ,  $R^7$ ,  $R^{13}$  and  $R^{16}$  each represent the same  $C_1$ - $C_6$  alkyl, particularly non-  
35 substituted  $C_1$ - $C_6$  alkyl, such as methyl, ethyl, n-propyl, iso-propyl, n-butyl, iso-butyl, tert-butyl, pentyl, hexyl or cyclohexyl;  $R^5$ ,  $R^8$ ,  $R^{14}$  and  $R^{17}$  each independently represent the

same C<sub>1</sub>-C<sub>6</sub> alkyl as defined above; and R<sup>6</sup>, R<sup>9</sup>, R<sup>15</sup> and R<sup>18</sup> each independently represent the same C<sub>1</sub>-C<sub>6</sub> alkyl as defined above. For example: R<sup>4</sup>, R<sup>7</sup>, R<sup>13</sup> and R<sup>16</sup> each represent methyl; R<sup>5</sup>, R<sup>8</sup>, R<sup>14</sup> and R<sup>17</sup> each represent ethyl; and, R<sup>6</sup>, R<sup>9</sup>, R<sup>15</sup> and R<sup>18</sup> each represent n-butyl or n-pentyl.

5

In an especially preferred embodiment of the present invention each R<sup>4</sup> to R<sup>9</sup>, R<sup>13</sup> to R<sup>18</sup> and R<sup>28</sup> group represents the same lower alkyl, aryl, or Het moiety as defined herein. Preferably, when alkyl groups, each R<sup>4</sup> to R<sup>9</sup>, R<sup>13</sup> to R<sup>18</sup> represents the same C<sub>1</sub> to C<sub>6</sub> alkyl group, particularly non-substituted C<sub>1</sub>-C<sub>6</sub> alkyl, such as methyl, ethyl, n-propyl, iso-propyl, n-butyl, iso-butyl, tert-butyl, pentyl, hexyl and cyclohexyl. Most preferably, each R<sup>4</sup> to R<sup>9</sup>, R<sup>13</sup> to R<sup>18</sup> and R<sup>28</sup> represents methyl.

10

In the compound of formula I, preferably each Q<sup>1</sup>, Q<sup>2</sup> and Q<sup>3</sup> (when present) are the same. Most preferably, each Q<sup>1</sup>, Q<sup>2</sup> and Q<sup>3</sup> (when present) represents phosphorous.

15

Preferably, in the compound of formula I, R (when alkylene), A, B and J (when present) each independently represent C<sub>1</sub> to C<sub>6</sub> alkylene which is optionally substituted as defined herein, for example with lower alkyl groups. Preferably, the lower alkylene groups which R (when alkylene), A, B and J (when present) represent are non-substituted. A particular preferred lower alkylene which A, B and J may independently represent is -CH<sub>2</sub>- or -C<sub>2</sub>H<sub>4</sub>-. Most preferably, each of A, B and J (when present) represent the same lower alkylene as defined herein, particularly -CH<sub>2</sub>-. Particularly preferred lower alkylenes which R represents may be selected from ethylene (-C<sub>2</sub>H<sub>4</sub>-), propylene (-C<sub>3</sub>H<sub>6</sub>-) and butylene (-C<sub>4</sub>H<sub>8</sub>-), more preferably, ethylene or propylene, most preferably, propylene.

25

Preferably, in the compound of formula I when K, D, E or Z does not represent -J-Q<sup>3</sup>(CR<sup>13</sup>(R<sup>14</sup>)(R<sup>15</sup>))CR<sup>16</sup>(R<sup>17</sup>)(R<sup>18</sup>), K, D, E or Z represents hydrogen, lower alkyl, phenyl or lower alkylphenyl. More preferably, K, D, E or Z represent hydrogen, phenyl, C<sub>1</sub>-C<sub>6</sub> alkylphenyl or C<sub>1</sub>-C<sub>6</sub> alkyl, such as methyl, ethyl, propyl, butyl, pentyl and hexyl. Most preferably, K, D, E or Z represents hydrogen.

30

Preferably, in the compound of formula I when K, D, E and Z together with the carbon atoms of the aryl ring to which they are attached do not form a phenyl ring, K, D, E and Z each independently represent hydrogen, lower alkyl, phenyl or lower alkylphenyl. More preferably, K, D, E and Z each independently represent hydrogen, phenyl, C<sub>1</sub>-C<sub>6</sub> alkylphenyl or C<sub>1</sub>-C<sub>6</sub>

35



alkyl, such as methyl, ethyl, propyl, butyl, pentyl and hexyl. Even more preferably, K, D, E and Z represent the same substituent. Most preferably, they represent hydrogen.

Preferably, in the compound of formula I when K, D, E or Z does not represent  $-J-Q^3(CR^{13}(R^{14})(R^{15}))CR^{16}(R^{17})(R^{18})$  and K, D, E and Z together with the carbon atoms of the aryl ring to which they are attached do not form a phenyl ring, each of K, D, E and Z represent the same group selected from hydrogen, lower alkyl, aryl, or Het as defined herein; particularly hydrogen or  $C_1$ - $C_6$  alkyl (more particularly unsubstituted  $C_1$ - $C_6$  alkyl), especially hydrogen.

10 Preferably, in the compound of formula I when two of K, D, E and Z together with the carbon atoms of the aryl ring to which they are attached form a phenyl ring, then the phenyl ring is optionally substituted with one or more substituents selected from aryl, lower alkyl (which alkyl group may itself be optionally substituted or terminated as defined below), Het, halo, cyano, nitro,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  $SR^{27}$ ,  $C(O)SR^{27}$  or  
15  $C(S)NR^{25}R^{26}$  wherein  $R^{19}$  to  $R^{27}$  each independently represent hydrogen or lower alkyl (which alkyl group may itself be optionally substituted or terminated as defined herein). More preferably, the phenyl ring is not substituted by any substituents i.e. it bears hydrogen atoms only.

20 Preferred compounds of formula I include those wherein:

A and B each independently represent unsubstituted  $C_1$  to  $C_6$  alkylene;

K, D, Z and E each independently represent hydrogen,  $C_1$ - $C_6$  alkyl, phenyl,  $C_1$ - $C_6$  alkylphenyl  
25 or  $-J-Q^3(CR^{13}(R^{14})(R^{15}))CR^{16}(R^{17})(R^{18})$  where J represents unsubstituted  $C_1$  to  $C_6$  alkylene; or two of K, D, Z and E together with the carbon atoms of the aryl ring to which they are attached form a phenyl ring which is optionally substituted by one or more substituents selected from lower alkyl, phenyl or lower alkylphenyl.

30  $R^4$  to  $R^9$  and  $R^{13}$  to  $R^{18}$  each independently represent  $C_1$  to  $C_6$  alkyl, phenyl or  $C_1$  to  $C_6$  alkylphenyl.

Further preferred compounds of formula I include those wherein:

35 A and B both represent  $-CH_2-$  or  $C_2H_4$ , particularly  $CH_2$ ;

K, D, Z and E each independently represent hydrogen, C<sub>1</sub>-C<sub>6</sub> alkyl phenyl or C<sub>1</sub>-C<sub>6</sub> alkyl or -J-Q<sup>3</sup>(CR<sup>13</sup>(R<sup>14</sup>)(R<sup>15</sup>))CR<sup>16</sup>(R<sup>17</sup>)(R<sup>18</sup>) where J is the same as A; or two of K, D, E and Z together with the carbon atoms of the aryl ring to which they are attached form an unsubstituted phenyl ring;

5

R<sup>4</sup> to R<sup>9</sup> and R<sup>13</sup> to R<sup>18</sup> each independently represent C<sub>1</sub> to C<sub>6</sub> alkyl;

Still further preferred compounds of formula I include those wherein:

- 10 R<sup>4</sup> to R<sup>9</sup> and R<sup>13</sup> to R<sup>18</sup> are alkylene and are the same and each represents C<sub>1</sub> to C<sub>6</sub> alkyl, particularly methyl.

Still further preferred compounds of formula I include those wherein:

- 15 K, D, Z and E are each independently selected from the group consisting of hydrogen or C<sub>1</sub> to C<sub>6</sub> alkyl, particularly where each of K, D, Z and E represent the same group, especially where each of K, D, Z and E represent hydrogen; or

- 20 K represents -CH<sub>2</sub>-Q<sup>3</sup>(CR<sup>13</sup>(R<sup>14</sup>)(R<sup>15</sup>))CR<sup>16</sup>(R<sup>17</sup>)(R<sup>18</sup>) and D, Z and E are each independently selected from the group consisting of hydrogen or C<sub>1</sub> to C<sub>6</sub> alkyl, particularly where both D and E represent the same group, especially where D, Z and E represent hydrogen.

Especially preferred specific compounds of formula I include those wherein:

- 25 each R<sup>4</sup> to R<sup>9</sup> is the same and represents methyl;  
A and B are the same and represent -CH<sub>2</sub>-;  
K, D, Z and E are the same and represent hydrogen.

- 30 The present invention provides a process for the carbonylation of a vinyl ester comprising contacting a vinyl ester with carbon monoxide and a alkanol in the presence of a catalyst compound as defined in the present invention.

- 35 Suitably, the alkanol includes an organic molecule having a hydroxyl functional group. Preferably, the organic molecule having a hydroxyl functional group may be branched or linear, and comprises an alkanol, particularly a C<sub>1</sub>-C<sub>30</sub> alkanol, including aryl alkanols, which may be optionally substituted with one or more substituents selected from lower alkyl, aryl,

Het, halo, cyano, nitro,  $OR^{19}$ ,  $OC(O)R^{20}$ ,  $C(O)R^{21}$ ,  $C(O)OR^{22}$ ,  $NR^{23}R^{24}$ ,  $C(O)NR^{25}R^{26}$ ,  $C(S)R^{25}R^{26}$ ,  $SR^{27}$  or  $C(O)SR^{27}$  as defined herein. Highly preferred alkanols are  $C_1$ - $C_8$  alkanols such as methanol, ethanol, propanol, iso-propanol, iso-butanol, t-butyl alcohol, n-butanol, phenol and chlorocapryl alcohol. Although the monoalkanols are most preferred, poly-  
5 alkanols, preferably, selected from di-ols such as diols, triols, tetra-ols and sugars may also be utilised. Typically, such polyalkanols are selected from 1, 2-ethanediol, 1,3-propanediol, glycerol, 1,2,4 butanetriol, 2-(hydroxymethyl)-1,3-propanediol, 1,2,6 trihydroxyhexane, pentaerythritol, 1,1,1 tri(hydroxymethyl)ethane, nannose, sorbase, galactose and other sugars. Preferred sugars include sucrose, fructose and glucose. Especially preferred  
10 alkanols are methanol and ethanol. The most preferred alkanol is methanol.

The amount of alcohol is not critical. Generally, amounts are used in excess of the amount of vinyl ester compound to be carbonylated. Thus the alcohol may serve as the reaction solvent as well, although, if desired, separate solvents may also be used.

15

It will be appreciated that the end product of the reaction is determined at least in part by the source of alkanol used. Use of methanol conveniently produces the 2-acetoxy methyl propanoate or 3-acetoxymethyl propanoate.

20 In the process according to the present invention, the carbon monoxide may be used in pure form or diluted with an inert gas such as nitrogen, carbon dioxide or a noble gas such as argon. Small amounts of hydrogen, typically less than 5% by volume, may also be present.

The ratio (volume/volume) of vinyl ester to alkanol may vary between wide limits and suitably  
25 lies in the range of 1:0.1 to 1:10, preferably from between 2:1 to 1:2 and up to a large excess of alkanol when the latter is also the reaction solvent such as up to a 50:1 excess of alkanol.

The amount of the catalyst of the invention used in the carbonylation process of the vinyl ester is not critical. Good results may be obtained when, preferably, the amount of Group VIII B  
30 metal is in the range  $10^{-7}$  to  $10^{-1}$  moles per mole of vinyl ester, more preferably,  $10^{-6}$  to  $10^{-2}$  moles, most preferably  $10^{-5}$  to  $10^{-2}$  moles per mole of ester. Preferably, the amount of bidentate compound of formula I to unsaturated compound is in the range  $10^{-7}$  to  $10^{-1}$ , more preferably,  $10^{-6}$  to  $10^{-2}$ , most preferably,  $10^{-5}$  to  $10^{-2}$  moles per mole of vinyl ester.

35

Suitably, although non-essential to the invention, the carbonylation of a vinyl ester as defined herein may be performed in one or more aprotic solvents. Suitable solvents include ketones, such as for example methylbutylketone; ethers, such as for example anisole (methyl phenyl ether), 2,5,8-trioxanonane (diglyme), diethyl ether, dimethyl ether, tetrahydrofuran, diphenylether, diisopropylether and the dimethylether of di-ethylene-glycol; esters, such as for example methylacetate, dimethyladipate methyl benzoate, dimethyl phthalate and butyrolactone; amides, such as for example dimethylacetamide, N-methylpyrrolidone and dimethyl formamide; sulfoxides and sulphones, such as for example dimethylsulphoxide, diisopropylsulphone, sulfolane (tetrahydrothiophene-2,2-dioxide), 2-methylsulfolane, diethyl sulphone, tetrahydrothiophene 1,1-dioxide and 2-methyl-4-ethylsulfolane; aromatic compounds, including halo variants of such compounds eg. benzene, toluene, ethyl benzene o-xylene, m-xylene, p-xylene, chlorobenzene, o-dichlorobenzene, m-dichlorobenzene; alkanes, including halo variants of such compounds eg. hexane, heptane, 2,2,3-trimethylpentane, methylene chloride and carbon tetrachloride; nitriles eg. benzonitrile and acetonitrile.

15

Very suitable are aprotic solvents having a dielectric constant that is below a value of 50, more preferably in the range of 3 to 8, at 298.15 K and  $1 \times 10^5 \text{ Nm}^{-2}$ . In the present context, the dielectric constant for a given solvent is used in its normal meaning of representing the ratio of the capacity of a condenser with that substance as dielectric to the capacity of the same condenser with a vacuum for dielectric. Values for the dielectric constants of common organic liquids can be found in general reference books, such as the Handbook of Chemistry and Physics, 76<sup>th</sup> edition, edited by David R. Lide et al, and published by CRC press in 1995, and are usually quoted for a temperature of about 20°C or 25°C, i.e. about 293.15 K or 298.15 K, and atmospheric pressure, i.e. about  $1 \times 10^5 \text{ Nm}^{-2}$ , or can readily be converted to that temperature and pressure using the conversion factors quoted. If no literature data for a particular compound is available, the dielectric constant may be readily measured using established physico-chemical methods.

20

For example, the dielectric constant of anisole is 4.3 (at 294.2 K), of diethyl ether is 4.3 (at 293.2 K), of sulfolane is 43.4 (at 303.2 K), of methylpentanoate is 5.0 (at 293.2 K), of diphenylether is 3.7 (at 283.2 K), of dimethyladipate is 6.8 (at 293.2 K), of tetrahydrofuran is 7.5 (at 295.2 K), of methylnonanoate is 3.9 (at 293.2 K). A preferred solvent is anisole.

25

Due to the alkanol, an aprotic solvent will be generated by the reaction as the ester carbonylation product of the vinyl ester, carbon monoxide and the alkanol is an aprotic solvent.

30

35

The process may be carried out in an excess of aprotic solvent, i.e. at a ratio (v/v) of aprotic solvent to alkanol of at least 1:1. Preferably, this ratio ranges from 1:1 to 10:1 and more preferably from 1:1 to 5:1. Most preferably the ratio (v/v) ranges from 1.5:1 to 3:1.

5

Despite the foregoing it is preferred that the reaction is carried out in the absence of any external added aprotic solvent ie. an aprotic solvent not generated by the reaction itself.

The catalyst compounds of the present invention may act as a "heterogeneous" catalyst or a  
10 "homogeneous" catalyst.

By the term "homogeneous" catalyst we mean a catalyst, i.e. a compound of the invention, which is not supported but is simply admixed or formed in-situ with the reactants of the carbonylation reaction (e.g. the vinyl ester, the hydroxyl containing compound and carbon  
15 monoxide), preferably in a suitable solvent as described herein.

By the term "heterogeneous" catalyst we mean a catalyst, i.e. the compound of the invention, which is carried on a support.

20 Thus according to a further aspect, the present invention provides a process for the carbonylation of vinyl esters as defined herein wherein the process is carried out with the catalyst comprising a support, preferably an insoluble support.

Preferably, the support comprises a polymer such as a polyolefin, polystyrene or polystyrene  
25 copolymer such as a divinylbenzene copolymer or other suitable polymers or copolymers known to those skilled in the art; a silicon derivative such as a functionalised silica, a silicone or a silicone rubber; or other porous particulate material such as for example inorganic oxides and inorganic chlorides.

30 Preferably the support material is porous silica which has a surface area in the range of from 10 to 700 m<sup>2</sup>/g, a total pore volume in the range of from 0.1 to 4.0 cc/g and an average particle size in the range of from 10 to 500 μm. More preferably, the surface area is in the range of from 50 to 500 m<sup>2</sup>/g, the pore volume is in the range of from 0.5 to 2.5 cc/g and the average particle size is in the range of from 20 to 200 μm. Most desirably the surface area is in the range of  
35 from 100 to 400 m<sup>2</sup>/g, the pore volume is in the range of from 0.8 to 3.0 cc/g and the average particle size is in the range of from 30 to 100 μm. The average pore size of typical porous



support materials is in the range of from 10 to 1000 Å. Preferably, a support material is used that has an average pore diameter of from 50 to 500 Å, and most desirably from 75 to 350 Å. It may be particularly desirable to dehydrate the silica at a temperature of from 100°C to 800°C anywhere from 3 to 24 hours.

5

Suitably, the support may be flexible or a rigid support, the insoluble support is coated and/or impregnated with the compounds of the process of the invention by techniques well known to those skilled in the art.

10 Alternatively, the compounds of the process of the invention are fixed to the surface of an insoluble support, optionally via a covalent bond, and the arrangement optionally includes a bifunctional spacer molecule to space the compound from the insoluble support.

The compounds of the invention may be fixed to the surface of the insoluble support by  
15 promoting reaction of a functional group present in the compound of formula I, for example a substituent K, D, Z and E of the aryl moiety, with a complimentary reactive group present on or previously inserted into the support. The combination of the reactive group of the support with a complimentary substituent of the compound of the invention provides a heterogeneous catalyst where the compound of the invention and the support are linked via a linkage such as  
20 an ether, ester, amide, amine, urea, keto group.

The choice of reaction conditions to link a compound of the process of the present invention to the support depend upon the vinyl ester and the groups of the support. For example, reagents such as carbodiimides, 1,1'-carbonyldiimidazole, and processes such as the use of mixed  
25 anhydrides, reductive amination may be employed.

According to a further aspect, the present invention provides the use of the process of any aspect of the invention wherein the catalyst is attached to a support.

30 Particularly preferred is when the organic groups  $R^4$ ,  $R^5$ ,  $R^6$ ,  $R^7$ ,  $R^8$ ,  $R^9$ , or  $R^{13} - R^{18}$  when associated with their respective carbon atom form composite groups which are at least as sterically hindering as t-butyl. Steric hindrance in this context is as discussed at page 14 et seq of "Homogenous Transition Metal Catalysis – A Gentle Art", by C Masters, published by Chapman and Hall 1981. These steric groups may be cyclic, part-cyclic or acyclic. When  
35 cyclic or part cyclic, the group may be substituted or unsubstituted or be saturated or unsaturated. The cyclic or part cyclic groups may contain, including the tertiary carbon atom,

from C<sub>4</sub>-C<sub>30</sub>, more preferably C<sub>6</sub>-C<sub>20</sub>, most preferably C<sub>10</sub>-C<sub>15</sub> carbon atoms in the cyclic structure. The cyclic structure may be substituted by one or more substituents selected from halo, cyano, nitro, OR<sup>19</sup>, OC(O)R<sup>20</sup>, C(O)R<sup>21</sup>, C(O)OR<sup>22</sup>, NR<sup>23</sup>R<sup>24</sup>, C(O)NR<sup>25</sup>R<sup>26</sup>, SR<sup>27</sup>, C(O)SR<sup>27</sup>, C(S)NR<sup>25</sup>R<sup>26</sup>, aryl or Het, wherein R<sup>19</sup> to R<sup>27</sup> each independently represent  
 5 hydrogen, aryl or lower alkyl, and/or be interrupted by one or more oxygen or sulphur atoms, or by silano or dialkylsilcon groups.

The bridging group Ar is an aryl moiety, eg. a phenyl group, which may be optionally substituted, provided that the two phosphorus atoms are linked to adjacent carbon atoms, eg. at  
 10 the 1 and 2 positions on the phenyl group. Furthermore, the aryl moiety may be a fused polycyclic group eg. naphthalene, biphenylene or indene.

Examples of suitable bidentate ligands are 1,2-bis(di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-  
 adamantylphosphinomethyl})ferrocene, 1,2-bis(di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-  
 15 adamantylphosphinomethyl})benzene, 1,2,3-tris-( di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-  
 adamantylphosphinomethyl}) ferrocene; 1- (2{1,3,5,7-tetramethyl-6,9,10-trioxa-  
 adamantyl}phosphinomethyl) – 2 – (di-t-butylphosphinomethyl) benzene;  
 1- (2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantyl}phosphinomethyl) –2-  
 (diadamantylphosphinomethyl) benzene; 1,2 bis (di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-  
 20 adamantylphosphinomethyl} ) naphthalene;

1,2-P,P'-di(2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo-{3.3.1.1[3.7]}decyl)ethane  
 (DPA2); 1,3-P,P'-di(2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo{3.3.1.1[3.7]}-  
 decyl)propane (DPA3); 1,2-P,P'-di-perfluoro(2-phospha-1,3,5,7-tetramethyl-6,9,10-  
 25 trioxatricyclo{3.3.1.1[3.7]}-decyl)ethane; 1,3-P,P'-di-perfluoro(2-phospha-1,3,5,7-  
 tetramethyl-6,9,10-trioxatricyclo{3.3.1.1[3.7]}decyl)-propane; 1,2-P,P'-di-(2-phospha-  
 1,3,5,7-tetra(trifluoro-methyl)-6,9,10-trioxatricyclo{3.3.1.1[3.7]}decyl)ethane and 1,3-P,P'-  
 di-(2-phospha-1,3,5,7-tetra(trifluoro-methyl)-6,9,10-trioxatricyclo{3.3.1.1[3.7]}decyl)  
 propane, DPA3 being most preferred.

30

Additionally, the bidentate phosphine may be bonded to a suitable polymeric substrate via at  
 least one of the bridging group Ar, the linking group A or the linking group B eg. bis (di-  
 2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantylphosphino} )-o-xylene may be bonded via the  
 xylene group to polystyrene to give an immobile heterogeneous catalyst.

35

The amount of bidentate ligand used can vary within wide limits. Preferably, the bidentate ligand is present in an amount such that the ratio of the number of moles of the bidentate ligand present to the number of moles of the Group VIII metal present is from 1 to 50 eg. 1 to 10 and particularly from 1 to 5 mol per mol of metal. More preferably, the mol:mol range of compounds of formula I to Group VIIIB metal is in the range of 1:1 to 3:1, most preferably in the range of 1:1 to 1.5:1. Conveniently, the possibility of applying these low molar ratios is advantageous, as it avoids the use of an excess of the compound of formula I and hence minimises the consumption of these usually expensive compounds. Suitably, the catalysts of the invention are prepared in a separate step preceding their use in-situ in the carbonylation reaction of a vinyl ester.

Conveniently, the process of the invention may be carried out by dissolving the Group VIIIB metal or compound thereof as defined herein in a suitable solvent such as one of the alkanols or aprotic solvents previously described (a particularly preferred solvent would be the ester or acid product of the specific carbonylation reaction eg. Methyl lactate for vinyl acetate carbonylation) and subsequently admixing with a compound of formula I as defined herein.

The carbon monoxide may be used in the presence of other gases which are inert in the reaction. Examples of such gases include hydrogen, nitrogen, carbon dioxide and the noble gases such as argon.

The molar ratio of the amount of vinyl ester used in the reaction to the amount of alkanol is not critical and may vary between wide limits, eg. from 0.001:1 to 100:1 mol/mol.

25

The product of the reaction may be separated from the other components by any suitable means. However, it is an advantage of the present process that significantly fewer by-products are formed thereby reducing the need for further purification after the initial separation of the product as may be evidenced by the generally significantly higher selectivity. A further advantage is that the other components which contain the catalyst system which may be recycled and/or reused in further reactions with minimal supplementation of fresh catalyst.

Preferably, the carbonylation is carried out at a temperature of between  $-10$  to  $150^{\circ}\text{C}$ , more preferably  $0^{\circ}\text{C}$  to  $140^{\circ}\text{C}$ , most preferably  $20^{\circ}\text{C}$  to  $120^{\circ}\text{C}$ . An especially preferred temperature is one chosen between  $80^{\circ}\text{C}$  to  $120^{\circ}\text{C}$ . Advantageously, the carbonylation can be carried out at

35

moderate temperatures, it is particularly advantageous to be able to carry out the reaction at room temperature (20°C).

Preferably, when operating a low temperature carbonylation, the carbonylation is carried out  
5 between -30°C to 49°C, more preferably, -10°C to 45°C, still more preferably 0°C to 45°C, most preferably 10°C to 45°C. Especially preferred is a range of 10 to 35°C.

Preferably, the carbonylation is carried out at a CO partial pressure of between  $0.80 \times 10^5 \text{ N.m}^{-2}$ - $90 \times 10^5 \text{ N.m}^{-2}$ , more preferably  $1 \times 10^5 \text{ N.m}^{-2}$ - $65 \times 10^5 \text{ N.m}^{-2}$ , most preferably  $1-30 \times 10^5 \text{ N.m}^{-2}$ .  
10 2. Especially preferred is a CO partial pressure of 5 to  $20 \times 10^5 \text{ N.m}^{-2}$ .

Preferably, a low pressure carbonylation is also envisaged. Preferably, when operating a low pressure carbonylation the carbonylation is carried out at a CO partial pressure of between 0.1 to  $5 \times 10^5 \text{ N.m}^{-2}$ , more preferably 0.2 to  $2 \times 10^5 \text{ N.m}^{-2}$ , most preferably 0.5 to  $1.5 \times 10^5 \text{ N.m}^{-2}$ .  
15

The catalyst system of the present invention is preferably constituted in the liquid phase which may be formed by one or more of the reactants or by the use of a suitable solvent.

As mentioned above, vinyl acetate can be substituted or non-substituted. However, it is  
20 preferred that the vinyl acetate is unsubstituted.

The use of stabilising compounds with the catalyst system may also be beneficial in improving recovery of metal which has been lost from the catalyst system. When the catalyst system is utilized in a liquid reaction medium such stabilizing compounds may assist recovery of the  
25 group VIII B metal.

Preferably, therefore, the catalyst system includes in a liquid reaction medium a polymeric dispersant dissolved in a liquid carrier, said polymeric dispersant being capable of stabilising a colloidal suspension of particles of the group VIII B metal or metal compound of the  
30 catalyst system within the liquid carrier.

The liquid reaction medium may be a solvent for the reaction or may comprise one or more of the reactants or reaction products themselves. The reactants and reaction products in liquid form may be miscible with or dissolved in a solvent or liquid diluent.

The polymeric dispersant is soluble in the liquid reaction medium, but should not significantly increase the viscosity of the reaction medium in a way which would be detrimental to reaction kinetics or heat transfer. The solubility of the dispersant in the liquid medium under the reaction conditions of temperature and pressure should not be so great as to  
5 deter significantly the adsorption of the dispersant molecules onto the metal particles.

The polymeric dispersant is capable of stabilising a colloidal suspension of particles of said group VIII B metal or metal compound within the liquid reaction medium such that the metal particles formed as a result of catalyst degradation are held in suspension in the liquid  
10 reaction medium and are discharged from the reactor along with the liquid for reclamation and optionally for re-use in making further quantities of catalyst. The metal particles are normally of colloidal dimensions, e.g. in the range 5 - 100 nm average particle size although larger particles may form in some cases. Portions of the polymeric dispersant are adsorbed onto the surface of the metal particles whilst the remainder of the dispersant molecules  
15 remain at least partially solvated by the liquid reaction medium and in this way the dispersed group VIII B metal particles are stabilised against settling on the walls of the reactor or in reactor dead spaces and against forming agglomerates of metal particles which may grow by collision of particles and eventually coagulate. Some agglomeration of particles may occur even in the presence of a suitable dispersant but when the dispersant type and concentration is  
20 optimised then such agglomeration should be at a relatively low level and the agglomerates may form only loosely so that they may be broken up and the particles redispersed by agitation.

The polymeric dispersant may include homopolymers or copolymers including polymers such  
25 as graft copolymers and star polymers.

Preferably, the polymeric dispersant has sufficiently acidic or basic functionality to substantially stabilise the colloidal suspension of said group VIII B metal or metal compound.  
30

By substantially stabilise is meant that the precipitation of the group VIII B metal from the solution phase is substantially avoided.

Particularly preferred dispersants for this purpose include acidic or basic polymers including  
35 carboxylic acids, sulphonic acids, amines and amides such as polyacrylates or heterocycle,



particularly nitrogen heterocycle, substituted polyvinyl polymers such as polyvinyl pyrrolidone or copolymers of the aforesaid.

5 Examples of such polymeric dispersants may be selected from polyvinylpyrrolidone, polyacrylamide, polyacrylonitrile, polyethylenimine, polyglycine, polyacrylic acid, polymethacrylic acid, poly(3-hydroxybutyric acid), poly-L-leucine, poly-L-methionine, poly-L-proline, poly-L-serine, poly-L-tyrosine, poly(vinylbenzenesulphonic acid) and poly(vinylsulphonic acid).

10 Preferably, the polymeric dispersant incorporates acidic or basic moieties either pendant or within the polymer backbone. Preferably, the acidic moieties have a dissociation constant ( $pK_a$ ) of less than 6.0, more preferably, less than 5.0, most preferably less than 4.5. Preferably, the basic moieties have a base dissociation constant ( $pK_b$ ) being of less than 6.0, more preferably less than 5.0 and most preferably less than 4.5,  $pK_a$  and  $pK_b$  being measured  
15 in dilute aqueous solution at 25°C.

Suitable polymeric dispersants, in addition to being soluble in the reaction medium at reaction conditions, contain at least one acidic or basic moiety, either within the polymer backbone or as a pendant group. We have found that polymers incorporating acid and amide moieties  
20 such as polyvinylpyrrolidone (PVP) and polyacrylates such as polyacrylic acid (PAA) are particularly suitable. The molecular weight of the polymer which is suitable for use in the invention depends upon the nature of the reaction medium and the solubility of the polymer therein. We have found that normally the average molecular weight is less than 100,000. Preferably, the average molecular weight is in the range 1,000 - 200,000, more preferably,  
25 5,000 - 100,000, most preferably, 10,000 - 40,000 e.g. Mw is preferably in the range 10,000 - 80,000, more preferably 20,000 - 60,000 when PVP is used and of the order of 1,000 - 10,000 in the case of PAA.

The effective concentration of the dispersant within the reaction medium should be  
30 determined for each reaction/catalyst system which is to be used.

The dispersed group VIII B metal may be recovered from the liquid stream removed from the reactor e.g. by filtration and then either disposed of or processed for re-use as a catalyst or other applications. In a continuous process the liquid stream may be circulated through an  
35 external heat-exchanger and in such cases it may be convenient to locate filters for the palladium particles in these circulation apparatus.

Preferably, the polymer:metal mass ratio in g/g is between 1:1 and 1000:1, more preferably, between 1:1 and 400:1, most preferably, between 1:1 and 200:1. Preferably, the polymer:metal mass ratio in g/g is up to 1000, more preferably, up to 400, most preferably, up to 200.

Preparation of 1,2-bis-(di-(1,3,5,7-tetramethyl-6,9,10-trioxa-2-phospho-adamantylmethyl))ferrocene

1,3,5,7-tetramethyl-2,4,8-trioxa-6-phospha-adamantane (obtained from Cytec, 14.0g, 0.066 mol) was added to a solution of 1,2-bis(dimethylaminomethyl)ferrocene (Example 1, 10 g, 0.033 mol) in anhydrous acetic acid (100 ml) under nitrogen and the resulting mixture is stirred at 80°C for 72 hours. The anhydrous acetic acid is removed *in vacuo* at approximately 70°C to yield the crude title product as an orange/yellow solid. This is washed with hot methanol to give the product as a mixture of isomers as an orange solid. (12.0g, 58%).

<sup>1</sup>H NMR (250 MHz; CDCl<sub>3</sub>): δ 4.25-3.95 (8H, br, m); 3.46 (4H, br); 1.57-2.0 (8H, br, m); 1.43-1.23 (24H, br m).

<sup>31</sup>P NMR (101 MHz; CDCl<sub>3</sub>): δ -27.41 (br), -29.01 (s), -33.9 (br) ppm.

Elemental analysis: Found: C:57.80%; H:7.35% Calculated: C:57.87%; H:7.40%

Synthesis of 1,2-P,P'-di (2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo [3.3.1.1<sup>3,7</sup>]decyl)-methylene-benzene

Synthesis step 1:

To a solution of 2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo[3.3.1.1<sup>3,7</sup>]decane hydride (H-PA) (13g, 60 mmol) in tetrahydrofuran (40ml) was added a 1 M solution of boron trihydride (73 mmol) in tetrahydrofuran over 5 min at 0 °C. After 4 h stirring at room temperature (20 °C), the solvent was removed and the crude product was recrystallised from the minimum volume hot tetrahydrofuran (20ml) and washed with hexane (2 x 5 ml) to afford 2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo [3.3.1.1<sup>3,7</sup>] decane borane (H-PA.BH<sub>3</sub>) as colourless crystals. Further product was obtained by recrystallisation of the filtrate from hot tetrahydrofuran (7 ml). The yield of H-PA.BH<sub>3</sub> was 86% based on H-PA.

Synthesis step 2 :

To a solution of H-PA.BH<sub>3</sub> (3.67g, 16 mmol) in tetrahydrofuran (40 ml) was added  
 5 hexyllithium (6.4 ml(2.5 M), 16 mmol) at -75 °C. After stirring for 1 h, α,α'-dibromo-o-  
 xylene (2.1 g, 8 mmol) in tetrahydrofuran (20 ml) was added at -75 °C and the reaction  
 allowed to warm to room temperature. After 3 hours, diethylamine (3 ml, 28 mmol) was  
 added and the reaction refluxed for 2 hours. After cooling, the solvent was removed and the  
 crude product dissolved in toluene (60 ml) and washed with water (4 x 40 ml). The solvent  
 10 was removed to afford 1,2-P,P<sup>1</sup>-di(2-phospha-1,3,5,7-tetramethyl-6,9,10-  
 trioxatricyclo[3.3.1.1{3.7}]decyl)-methylene-benzene (3.9 g, 91%) as a white solid (see thesis  
 by Robert Pugh submitted to the University of Bristol in April 2000 for NMR  
 characterization). The diphosphine may be further purified by recrystallisation from methanol.

15 **Vinyl Acetate Carbonylation**

**1,2-bis(di-2{1,3,5-trimethyl-6,9,10-trioxa-adamantylphosphinomethyl})ferrocene (FePA)**  
**(Metal:Ligand:Acid ratio (M:L:A ratio) =1:1.25:2)**

20 Standard conditions were as follows : In an oxygen free (< 10 ppm O<sub>2</sub>) environment Pd(OAc)<sub>2</sub>  
 (134.7mg, 0.6mmoles Pd) and 1,2-bis(di-2{1,3,5-trimethyl-6,9,10-trioxa-  
 adamantylphosphinomethyl})ferrocene (492.3mg, 0.75mmoles) were weighed into a 500ml  
 round bottom flask. To this under a protective atmosphere of nitrogen 300ml of degassed  
 methanol was added, and the solution allowed to stir for one hour. Then methane sulphonic  
 25 acid (77.9ul, 1.2mmoles,) was added and 50ml of degassed vinyl acetate (VAM). This solution  
 was added to an autoclave under vacuum, and heated to 60°C, when 10 bar of CO was added,  
 and the solution allowed to react for 3 hours. The solution was then cooled, the pressure  
 released, and the autoclave emptied. A GC sample was taken for analysis.

Run	Ligand	Linear:		% Conversion	
		Branched Ratio	% Conversion to Products	of VAM	to Products
1	FePA	5.99	56.63	56.33	
2	FePA	5.87	64.75	64.07	
3	FePA	5.93	60.38	60.00	

**1,2-bis(di-2{1,3,5-trimethyl-6,9,10-trioxa-adamantylphosphinomethyl})benzene (XylyPA)**  
**(M:L:A ratio =1:1.25:2)**

5 Standard conditions were as follows : In an oxygen free (< 10 ppm O<sub>2</sub>) environment Pd(OAc)<sub>2</sub> (134.7mg, 0.6mmoles Pd) and 1,2-bis(di-2{1,3,5-trimethyl-6,9,10-trioxa-adamantylphosphinomethyl})benzene (411.4mg, 0.75mmoles) were weighed into a 500ml round bottom flask. To this under a protective atmosphere of nitrogen 300ml of degassed methanol was added, and the solution allowed to stir for one hour. Then methane sulphonic  
 10 acid (77.9ul, 1.2mmoles,) was added and 50ml of degassed vinyl acetate (VAM). This solution was added to an autoclave under vacuum, and heated to 60°C, when 10 bar of CO was added, and the solution allowed to react for 3 hours. The solution was then cooled the pressure released, and the autoclave emptied. A GC sample was taken for analysis.

Run	Ligand	Linear:	% Conversion	
		Branched Ratio	% Conversion to Products	of VAM to Products
1	XylyPA	6.16	62.07	61.83

15

After distillation of the products of the carbonylation, 2-acetoxy methyl propionate and 3-acetoxy methyl propionate were collected as different distillates.

20 Production of Lactate and 3-hydroxy Esters

Preparation of 3 hydroxymethylpropionate

To 25g of 3 acetoxy methyl propionate (0.171 moles) was added 25g MeOH (0.78 moles) containing 1%w/w methane sulphonic acid . The solution was stirred at 60C for six  
 25 hours before cooling to room temperature. The sample was analysed by GC, the peak corresponding to 3 acetoxy methylpropionate had completely disappeared and been replaced by a peak corresponding to 3 hydroxymethylpropionate.

Preparation of 2-hydroxymethylpropionate

30

To 25g of 2 acetoxy methylpropionate (0.171 moles) was added 25g MeOH (0.78

moles) containing 1%w/w methane sulphonic acid. The solution was stirred at 60C for six hours before cooling to room temperature. The sample was analysed by GC, the peak corresponding to 2 acetoxy methylpropionate had completely disappeared and been replaced by a peak corresponding to 2 hydroxymethylpropionate.

5

Preparation of 2 hydroxy propionic acid (lactic acid)

To 25g of 2 acetoxy methyl propionate (0.171 moles) was added 25g MeOH. To this stirred solution was added 20g sodium hydroxide (0.5 moles) dissolved in 20 ml of water. The solution was stirred for one hour at 50C before cooling to room temperature. The pH of the solution was then adjusted to pH 3.0 by the slow addition of HCl and the sample stirred for 1 hour. The sample was analysed by GC, the peak corresponding to 2 acetoxy methyl propionate had completely disappeared and been replaced by a peak corresponding to 2 hydroxy propionic acid.

15

Preparation of 3 hydroxy propionic acid

To 25g of 3 acetoxy methyl propionate (0.171 moles) was added 25g MeOH. To this stirred solution was added 20g sodium hydroxide (0.5 moles) dissolved in 20 ml of water. The solution was stirred for one hour at 50C before cooling to room temperature. The pH of the solution was then adjusted to pH 3.0 by the slow addition of HCl and the sample stirred for 1 hour. The sample was analysed by GC, the peak corresponding to 3 acetoxy methyl propionate had completely disappeared and been replaced by a peak corresponding to 3 hydroxy propionic acid.

25

The reader's attention is directed to all papers and documents which are filed concurrently with or previous to this specification in connection with this application and which are open to public inspection with this specification, and the contents of all such papers and documents are incorporated herein by reference.

30

All of the features disclosed in this specification (including any accompanying claims, abstract and drawings), and/or all of the steps of any method or process so disclosed, may be combined in any combination, except combinations where at least some of such features and/or steps are mutually exclusive.

35



Each feature disclosed in this specification (including any accompanying claims, abstract and drawings), may be replaced by alternative features serving the same, equivalent or similar purpose, unless expressly stated otherwise. Thus, unless expressly stated otherwise, each feature disclosed is one example only of a generic series of equivalent or similar features.

5

The invention is not restricted to the details of the foregoing embodiment(s). The invention extends to any novel one, or any novel combination, of the features disclosed in this specification (including any accompanying claims, abstract and drawings), or to any novel one, or any novel combination, of the steps of any method or process so disclosed.

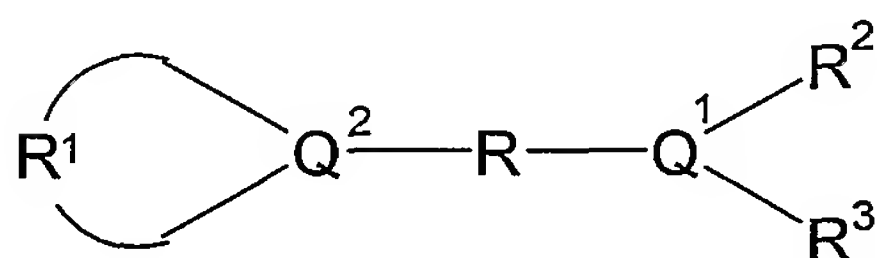
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## CLAIMS

1. A process for the alkoxycarbonylation of a vinyl ester comprising reacting a vinyl ester with carbon monoxide in the presence of an alkanol and of a catalyst system, the catalyst system obtainable by combining:

- (c) a metal of Group VIII B or a compound thereof; and
- (d) a bidentate ligand of general formula (I)

10 (I)



15

wherein:

R is a covalent bridging group;

R<sup>1</sup> together with Q<sup>2</sup> to which it is attached form an optionally substituted 2-Q<sup>2</sup>-tricyclo[3.3.1.1{3,7}]decyl group or derivative thereof(2-PA);

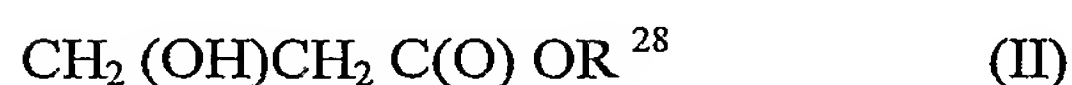
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R<sup>2</sup> and R<sup>3</sup> independently represent univalent radicals upto 20 atoms or jointly form a bivalent radical of up to 20 atoms;

Q<sup>1</sup> and Q<sup>2</sup> each independently represent phosphorous, arsenic or antimony.

25

2. A process for the production of 3-hydroxy propanoate ester or acid of formula (II)



30 comprising the steps of:

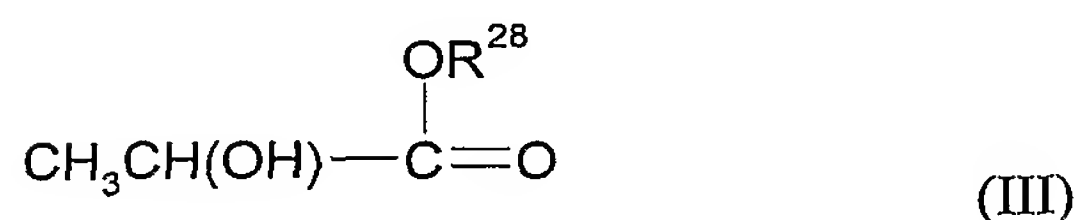
alkoxycarbonylating vinyl ester with carbon monoxide in the presence of an alkanol and a catalyst system, the catalyst system obtainable by combining:

- (a) a metal of Group VIII B or a compound thereof; and
- (b) a bidentate ligand of general formula (I) in accordance with claim 1

wherein  $R^{28}$  is selected from H, or a  $C_1$ - $C_{30}$  alkyl or aryl moiety which may be substituted or  
 5 unsubstituted and either branched or linear and carrying out a treatment step on the said linear  
 (n) product 1-acetoxy  $CH_2CH_2C(O)OR^{28}$  to produce the 3-hydroxy propanoate ester or acid of  
 formula (II).

3. A process for the production of a lactate ester or acid of formula III

10



comprising the steps of alkoxycarbonylating vinyl ester with carbon monoxide in the presence  
 of an alkanol and a catalyst system, the catalyst system obtainable by combining:

15

- (a) a metal of Group VIII B or a compound thereof; and
- (b) a bidentate ligand of general formula (I) in accordance with claim 1

to produce a product comprising a branched (iso) product 2-acetoxy  $(CH_3)_2CH.C(O)OR^{28}$   
 20 wherein  $R^{28}$  is selected from H, or a  $C_1$ - $C_{30}$  alkyl or aryl moiety which may be substituted or  
 unsubstituted and either branched or linear and chemically treating the said branched (iso)  
 product to produce the corresponding lactate or acid of formula III.

4. A process according to any of claims 1-3, wherein  $Q^2$  is phosphorous.

25

5. A process according to any of claims 1-4, wherein  $R^2$  represents  $CR^4(R^5)(R^6)$ , congressyl or  
 adamantyl,  $R^3$  represents  $CR^7(R^8)(R^9)$ , congressyl or adamantyl, or  $R^2$  and  $R^3$  together with  $Q^1$   
 to which they are attached form an optionally substituted 2- $Q^1$ -tricyclo[3.3.1.1{3,7}]decyl  
 group or derivative thereof.

30

6. A process according to any claims 1-5, wherein the adamantyl group optionally comprises,  
 besides hydrogen atoms, one or more substituents selected from lower alkyl,  $-OR^{19}$ ,  $-$   
 $OC(O)R^{20}$ , halo, nitro,  $-C(O)R^{21}$ ,  $-C(O)OR^{22}$ , cyano, aryl,  $-N(R^{23})R^{24}$ ,  $-C(O)N(R^{25})R^{26}$ ,  $-$   
 $C(S)(R^{27})R^{28}$ ,  $-CF_3$ ,  $-P(R^{56})R^{57}$ ,  $-PO(R^{58})(R^{59})$ ,  $-PO_3H_2$ ,  $-PO(OR^{60})(OR^{61})$ , or  $-SO_3R^{62}$ , wherein

$R^{19}$ ,  $R^{20}$ ,  $R^{21}$ ,  $R^{22}$ ,  $R^{23}$ ,  $R^{24}$ ,  $R^{25}$ ,  $R^{26}$ ,  $R^{27}$ ,  $R^{28}$ , lower alkyl, cyano and aryl are as defined herein and  $R^{56}$  to  $R^{62}$  each independently represent hydrogen, lower alkyl, aryl or Het.

7. A process according to claims 1-5, wherein the 2- $Q^2$ (or  $Q^1$ )-tricyclo[3.3.1.1.{3,7}]decyl group (referred to hereinafter as a 2-meta-adamantyl group for convenience wherein 2-meta-adamantyl is a reference to 2-arsa-adamantyl and/or 2-stiba-adamantyl and/or 2-phospha-adamantyl), optionally comprises, beside hydrogen atoms, one or more such adamantyl substituents as defined in claim 6.
8. A process according to claim 7, wherein the 2-meta-adamantyl group includes additional heteroatoms, other than the 2- $Q$  atom, in the 2-meta-adamantyl skeleton.
9. A process according to any of claims 1-8, wherein the 2-meta-adamantyl groups as defined herein include 2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxadamantyl group, 2-phospha-1,3,5-trimethyl-6,9,10-trioxadamantyl group, 2-phospha-1,3,5,7-tetra(trifluoromethyl)-6,9,10-trioxadamantyl group, and 2-phospha-1,3,5-tri(trifluoromethyl)-6,9,10-trioxadamantyl group.
10. A process according to any of claims 1-9, wherein suitable Group VIII B metals or a compound thereof which may be combined with a compound of formula I include cobalt, nickel, palladium, rhodium and platinum.
11. A process according to any of claims 1-10, wherein the ratio of linear:branched product from the alkoxycarbonylation process is greater than 1.5:1.
12. A process according to any of claims 1-11, wherein the bidentate ligands are selected from 1,2-bis(di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantylphosphinomethyl})ferrocene, 1,2-bis(di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantylphosphinomethyl})benzene, 1,2,3-tris-(di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantylphosphinomethyl})ferrocene; 1-(2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantyl}phosphinomethyl)-2-(di-*t*-butylphosphinomethyl)benzene; 1-(2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantyl}phosphinomethyl)-2-(diadamantylphosphinomethyl)benzene; 1,2-bis(di-2{1,3,5,7-tetramethyl-6,9,10-trioxa-adamantylphosphinomethyl})naphthalene; 1,2-*P,P'*-di(2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo-{3.3.1.1[3.7]}decyl)ethane (DPA2); 1,3-*P,P'*-di(2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo{3.3.1.1[3.7]}-decyl)propane (DPA3); 1,2-*P,P'*-di-perfluoro(2-phospha-1,3,5,7-tetramethyl-6,9,10-

trioxatricyclo{3.3.1.1[3.7]}-decyl)ethane; 1,3-P,P'-di-perfluoro(2-phospha-1,3,5,7-tetramethyl-6,9,10-trioxatricyclo{3.3.1.1[3.7]}decyl)-propane; 1,2-P,P'-di-(2-phospha-1,3,5,7-tetra(trifluoro-methyl)-6,9,10-trioxatricyclo{3.3.1.1[3.7]}decyl)ethane and 1,3-P,P'-di-(2-phospha-1,3,5,7-tetra(trifluoro-methyl)-6,9,10-trioxatricyclo{3.3.1.1[3.7]}decyl) propane;

or the bidentate ligand is bonded to a suitable polymeric substrate via at least one of a bridging group such as Ar, the linking group A or the linking group B.

13. The process according to any of claims 1-12, wherein the carbonylation is carried out at a temperature of between  $-10$  to  $150^{\circ}\text{C}$ .

14. The process according to any of claims 1-13, wherein the carbonylation is carried out at a CO partial pressure of between  $0.80 \times 10^5 \text{ N.m}^{-2}$ - $90 \times 10^5 \text{ N.m}^{-2}$ .

15. A process according to any of claims 1-14, wherein the group R represents an alkylene bridging group.

16. A process according to any of claims 1-14, wherein the bridging group R may be defined as -A-(K,D)Ar(E,Z)-B- wherein:

Ar is a bridging group comprising an optionally substituted aryl moiety to which the  $Q^1$  and  $Q^2$  atoms are linked on available adjacent carbon atoms;

A and B each independently represent lower alkylene;

K, D, E and Z are substituents of the aryl moiety (Ar) and each independently represent hydrogen, lower alkyl, aryl, Het, halo, cyano, nitro,  $\text{OR}^{19}$ ,  $\text{OC(O)R}^{20}$ ,  $\text{C(O)R}^{21}$ ,  $\text{C(O)OR}^{22}$ ,  $\text{NR}^{23}\text{R}^{24}$ ,  $\text{C(O)NR}^{25}\text{R}^{26}$ ,  $\text{C(S)R}^{25}\text{R}^{26}$ ,  $\text{SR}^{27}$ ,  $\text{C(O)SR}^{27}$ , or  $-\text{J-Q}^3(\text{X}^5)\text{X}^6$  where J represents lower alkylene; or two adjacent groups selected from K, Z, D and E together with the carbon atoms of the aryl ring to which they are attached form a further phenyl ring, which is optionally substituted by one or more substituents selected from hydrogen, lower alkyl, halo, cyano, nitro,  $\text{OR}^{19}$ ,  $\text{OC(O)R}^{20}$ ,  $\text{C(O)R}^{21}$ ,  $\text{C(O)OR}^{22}$ ,  $\text{NR}^{23}\text{R}^{24}$ ,  $\text{C(O)NR}^{25}\text{R}^{26}$ ,  $\text{C(S)R}^{25}\text{R}^{26}$ ,  $\text{SR}^{27}$  or  $\text{C(O)SR}^{27}$  or, when Ar is a cyclopentadienyl group, Z may be represented by  $-\text{M}(\text{L}_1)_n(\text{L}_2)_m$  and Z is connected via a metal ligand bond to the cyclopentadienyl group;



$X^5$  represents  $CR^{13}(R^{14})(R^{15})$ , congressyl or adamantyl,  $X^6$  represents  $CR^{16}(R^{17})(R^{18})$ , congressyl or adamantyl, or  $X^5$  and  $X^6$  together with  $Q^3$  to which they are attached form an optionally substituted 2- $Q^3$ -tricyclo[3.3.1.1{3,7}]decyl group or derivative thereof.

5

17. A process for the alkoxycarbonylation of a vinyl ester as described herein and with reference to the examples.

18. A process for the production of 3-hydroxy propanoate ester or acid of formula (II) as  
10 described herein and with reference to the examples.

19. A process for the production of a lactate ester or acid of formula III as described herein and with reference to the examples.

# INTERNATIONAL SEARCH REPORT

International Application No  
PCT/GB2005/001911

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C07C67/38 C07C69/67 C07C67/31 C07C69/675 C07C69/68  
C07C51/09 C07C59/01 C07C59/08

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C07C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, BEILSTEIN Data, CHEM ABS Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

° Special categories of cited documents:

- \*A\* document defining the general state of the art which is not considered to be of particular relevance
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- \*Y\* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
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Date of the actual completion of the international search

19 September 2005

Date of mailing of the international search report

26/09/2005

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# INTERNATIONAL SEARCH REPORT

International Application No  
PCT/GB2005/001911

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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